FEDERAL BUREAU OF INVESTIGATION FOI/PA
DELETED PAGE INFORMATION SHEET FOI/PA# 1389423-0

Total Deleted Page(s) = 2 Page 11 ~ b6; b7C; Page 12 ~ b6; b7C;

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U.S. Department of Justice

Federal Bureau of Investigation

In Reply, Please Refer to File No.	880 Front Street Suite 6-S-31 San Diego, California 92188	
	January 29, 1987	
	b6 Re: Bay City Marine b7C	
Dear :	not bu, ord, narrie	
containing documents pertain you furnished to the Feder August 11, 1982.	you herewith is your notebook ning to Bay City Marine which ral Bureau of Investigation on are no longer needed by this	
office.	-	
Thank you for your	cooperation.	
	Very truly yours,	
	THOMAS A. HUGHES Special Agent in Charge	
By:		ь6 ь7С

Enclosure



CHAIN OF POSSESSION Morriell Name Item No. Name 1 From: Bulku Date: > From: From: From: Date: Time: From: Time: Date: To; From: Time: Date: To: From: Time: Date: To: From: Time: Date: To: From: Time: Date: To: From: Remarks Item No. 33.57

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b6 b7C

UNITED STATES POSTAL SERVICE OFFICIAL BUSINESS

SENDER INSTRUCTIONS
Print your name, address, and ZIP Code
in the space below.

 Complete items 1, 2, 3, and 4 on the reverse.

 Attach to front of article if space permits, otherwise affix to back of article.

 Endorse article "Return Receipt Requested" adjacent to number.





PENALTY FOR PRIVATE USE. \$300



Print Sender's name, address, and ZIP Code in the space below.

SPECIAL AGENT IN CHARGE

FEDERAL BUREAU OF INVESTIGATION

880 FRONT STREET, SUITE 6-S-31

SAN DIEGO, CALIFORNIA 92188

AHN ECC 206 A-58-213(3.)

Put your address in the "RETURN TO" space on the reverse and from being returned to you. The return receipt fee wild delivered to and the date of delivery. For additional fees the postmaster for fees and check box(es) for additional services. 1. Show to whom delivered, date, and addressee's a	se side. Failure to do this will prevent this I provide you the name of the person e following services are available. Consult e(s) requested.
	4. Article Number 38
5. Signature — Addressee X 6. Signature — Agent X 7. Date of Delivery	8. Addressee's Address (ONLY if requested and fee paid)
L PS Form 3811, Feb. 1986	DOMESTIC RETURN RECEIPT

U.S. Department of Justice Federal Bureau of Investigation 880 Front Street, Suite 6-S-31 San Diego, California 92188	REASON CHECKED Unclaimed X Refused Insuific, out address No such street No such street No such street
Official Business Penalty for Private Use \$300	No such office in state Do not fedical in this state of investigation JUS-432
	- A Salar X

b6 b7C PEGISTERED MAIL R 381 740 774

Claim Check 982457 1ST Notice
3 - 5
2ND Notice
3 - 10
Return Detached from PS Form 3849-A, Oct. 1985

18 JUNE 1981

BAY CITY MARINE QUALIFIED WELDERS & BRAZERS

b6 b7C

NAME	<u> </u>	BADGE	MMA	TIG	MIG	S-B	PLATE	PIPE
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CONTRACT 72-81 MODS

MOD-1 200749 & 20092	9 TIME I HR	MATERIAL	10070
MOD-2 200929	TIME ! HR	MATERIAL	8070
MOD-3 200929	TIME 16 HRS	MATERIAL	6070
MOD 4 200749 &200929	TIME 9HRS	MATERIAL	6870
MOD 5 200749 & 20092	9 TIME 12HRS	MATERIAL NONE	100%
MOD 6 200749 & 20092	9 TIME BHRS	MATERIAL NONE	100%
MOD 7 200929	TIME ZHRS	MATERIAL	5070
MOD 8 200749 & 20092	9 TIME ZY HRS	MATERIAL	5090
MOD 9 200749 & 20092	9 TIME 4 HRS	MATERIAL 5.00	5076
MOD 10 20074	9 TIME 3% HES	MATERIAL 1.30	10070
MOD 11 749 & 20092	9 TIME_O	MATERIAL	10070
MOD 12 749 & 20092	9 TIME 24 HRS	MATERIAL	3070
MOD 13 749 & 20092	9 TIME ZYHRS	MATERIAL	80%
MOD 14 20074	9 TIME IHR	MATERIAL	10070
MOD 15 20092	9 TIME ILOHRS	MATERIAL	9070
MOD 16 749 & 20092	9 TIME 24 HRS	MATERIAL	10076

ıpship San Diego	19 October 1981	1509-1D #60	
•	19 OCCODER 1901	1309-10 #00	
Bay City Marine			
1411 Harding Ave.	•6.	•7.	
National City, Ca. 92050			
••	1		b6
REFERENCE			b7C
SPECIFICATION	PAGE	LINE PARAGRAPH	
Clause 10 MSR		A & B	
proving no.	lar.		
PROCEDURE NO.	PARAGRAPH	PAGE	
OTHER (Specify)			
. THE FOLLOWING DEFICIENCY(IES) REQUIRE COR	DECTIVE ACTION AS TO		
CORRECTION OF DEFECT	X CORRECTION AS TO CAUS	: F	
	CALL COUNTRY OF TO CAUS	r ta	
ESCRIPTION OF DEFICIENCY (IES):			
L. Clause 10 of MSR States: Reas	sonable care to prevent da	amage to property shall	be
excerised by contractor.			
2. Port aft window pane on pilot	house was damaged due to	abrasive blasting	
	The same same see the	az. az i te z i az e i i i g .	
Contractors records do not ac	ddress this area.	7	
This item was discussed to F	-: 10 0	haban 1001 ku	
4. This item was discussed with	ou 19: 0c.	tober 1981 by	
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		nue on Back if More Space Requ	uired)
1. AUTHORIZED GOVT. REP. (Signature)	ODE *12.	**************************************	uired)
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D-10054

PLEASE GIVE ME A

ANSWER ON THIS IN

WRITING.

NEEP:

(a) CORRECTION TO DEFECT

(b) CORRECTION TO CAUSE

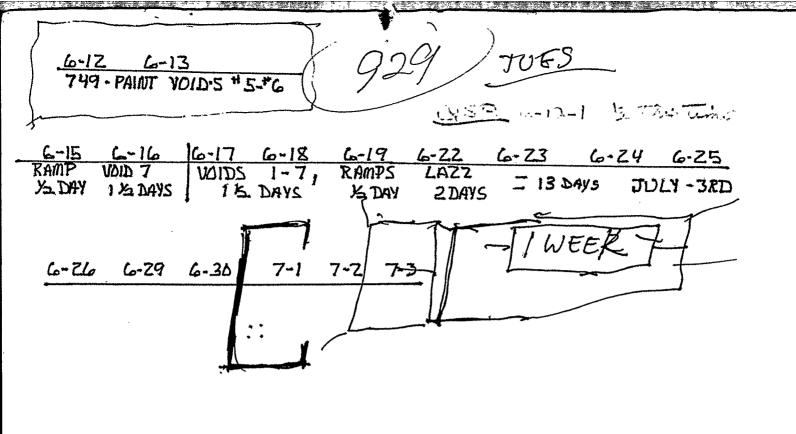
MUST BE BETURNED TO SUPSKIP

BY 10/24/81

b6 b7C

HAVSHIPS 4355/14 (9-72) (FRONT) (ICIENCY RECORD - H. *Optional Items)	ARDWARE	
Supship San Diego	19 October 1	981 1509-1) #60
To: Bay City Marine 1411 Harding Ave.	*6.	• 5.	
National City, Ca. 92050			ь6 ь7С
9. REFERENCE:			3.00
SPECIFICATION Clause 10 MSR			Paragraph A & B
PROCEDURE NO.	PARAG	RAPH ,PAGE	
OTHER (Specify)			
10. THE FOLLOWING DEFICIENCY(IES) REQUIRE CORRECT Correction of Deficiency(IES): 1. Clause 10 of MSR States: Reason excerised by contractor.	X CORRECTION AS T		erty shall be
 Port aft window pane on pilot ho Contractors records do not addr 	•	e to abrasive bla	sting.
4. This item was discussed with	on 1	6.October 1981 by	b'
		(Continue on Back if Ma	re Space Required)
CODE 15	609-1D	19 October 1981	b6 b7c
be provided to Supship Code 1509-1D 14. CONTRACTOR'S REPLY (Authorized Representative	by 26 October 1981		r to be taken
15. VERIFICATION & EVALUATION STATEMENT OF CONTR.	(Signa	•	(Date)
	•		
S/N 0105-LF-604-2390	SIGNATURE:	DATE:	
		Page	of

D-10054



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CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D

INSPECTION / DEFICIENCY REPORT

REPORT NO. 116-51 DATE SUBMITTED 11/16/81 CONTRACT NO. BCM 116-81 PLANNER/SURVEYOR INSPECTION DATE

b6 b7C

CW 00995-11,12,13

583-41-003 ART. NO. 583-41-004 MOD.

PT VIII

SUBJECT: USS LCM-8 765 & 783

SPEC. PKG. NO. SD 688-81

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

- Item 583-41-004 PT VIII, para 3.22 directs contractor to remove the propellers, but does not indicate re-installation.
- Upon completion of para 3.19, it became evident that the thrust support bracket is not in line with the rudder bearing and tube.
- Para 3.20.1 directs contractor to make adjustments to the rudders. Inspection reveals that the steering arms are badly bent in the adjustment areas, and contractor feels that they will break if straightening is attempted.

CONTRACTOR'S RECOMMENDED ACTION

- Request SUPSHIP direction.
- Issue contractor a change order to relocate support bracket for true alignment, total of four (4) brackets.
- Issue contractor a change order to replace the threaded areas.

		SIGNATURE O ORIGINATOR		
REPLY REQUESTED BY:	URGENT!!!!			
O COMPLETE ARTICLE W	ITHIN AVAILABILITY			
SUPERVISOR OF SHIPBUIL	DING REPRESENTATIVES FINDINGS AND/OR	RECOMMENDATIONS		b6 b7C
			11-19-01	טיע

MOD# 17 \$18 Applies

IU: LRV	•
FROM:	b6 b7С
SUBJ: EXPENSES FOR CONTRACT 72-81 SANDBLASTING	
1. THE FOLLOWING IS A PARTIAL LIST OF EXPENSES OCCCURED ON SANDBLAST	ING.
	1
Pel FULL ANIBULT	

X NEED TOTAL COST FOR REPLACEMENT OF FUEL OIL HOSES.

* NEED ALL INVOICES IN

WEEKLY TIME SHEET

Week Ending 19

BAY CITY MARINE, INC.

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WEEKLY TIME SHEET

Week Ending 19 1

BAY CITY MARINE, INC.

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WEEKLY TIME SHEET

Week Ending 124-1 19

BAY CITY MARINE, INC.

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NATIONAL PUMP & INJECTOR SALES & SERVICE, INC.

2307 East Belt Street

San Diego, California 92113

Phone: Area Code 714, 232-0831

October 14, 1981

Bay City Marine 1411 Harding Avenue National City, Calif

> Subject: U.S.S. Durham LKA-114 BCM 116-81, Spec #688-81 Item #583-41-004, LCM'8 2 each 12V71 G.M. Diesel Engines, S/N 12VA53220

> > S/N 12VA53217

Gentlemen:

The following conditions were noted and recorded during the disassembly, cleaning and inspecting of subject engines.

Engine S/N 12VA53220

Crankshaft cracked (See NDT Report). Crankshaft scored. Right st manifold broken. Right bank thermostat bousing the second state of the second exhaust manifold broken. Right bank thermostat housing broken No Water temp and fuel oil pressure sending units broken. Engine lube oil contaminated with fuel oil. Fuel oil jumper lines damaged. Both valve covers damaged. Blower coupling damaged. Blower drive gears rusty and pitted, Blower coupling cover damaged.

Trasmission & P.T.O.

Bearings worn and scored. Forward clutch plates worn and warped. Forward clutch springs broken.

Missing Parts Report

Generator, RPA Hydraulic pumps.

Engine S/N 12VA53217

Crankshaft worn beyond manufacture wear limits. Cam rollers worn and scored. Vibration dampner damaged.

Contin	iue	4.00	
	79.4	***:	
Transm	nission & P.T.O.		
	•		at an harab
		ings broken. Reverse spr rd and reverse clutch pla	
Missin	ng Parts Report .	etter m	•
	enerator, RPA Hyd		
Recomm	end the following	list of material be repa	aired and or replaced
_			
1	5146734 5162715	CRANKSHAFT RIGHT BANK EXHAUST M	ANTEOLD
1	5172628	RT BANK THERMOSTAT H	
1 12 1 2 1	5111527	FUEL OIL JUMPER LINE	I I I I I I I I I I I I I I I I I I I
1	5103744	VALVE COVERS	
ĺ	5149512 5103377	VALVE COVER INST KIT BLOWER COUPLING MIS	
1	5196763	DIONER COOPTING COAT	
12	5111526	FUEL OIL JUMPER LINE	ES (S)
			b
Transm	nission		Δ.
1	MA648	BALL BEARING	
1 2	MA647	ROLLER BEARING	
2	M2175B M2104	BALL BEARING BALL BEARING	
2	MA649	BALL BEARING	
1	M2475A	BALL BEARING	
1 2 1	MA293 M2167	BALL BEARING BALL BEARING	
-	112107	DALL DIAKING	
Engine	s/N 12VA53217		
	(NONE)		•
	(MOINE)		

Bay City Marine

Page #2

Bay City Marine

Page #3

Continue

Transmission b4 1 2 2 1 MA648 BALL BEARING BEARING, ROLLER MA647 BALL BEARING M2175B M2104 BALL BEARING BALL BEARING MA649 M2475A BALL BEARING 2, 1 BALL BEARING MA293 M2167 BALL BEARING

NY. .

Very	truly	yours,		
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NATIONAL PUMP & INJECTOR SALES & SERVICE, INC.

2307 East Belt Street

San Diego, California 92113

Phone: Area Code 714, 232-0831

October 14, 1981

Bay City Marine 1411 Harding Avenue National City, Calif 92050

> Subject: U.S.S. Durham LKA-114 BCM 116-81. Spec #SD688-81 Item #583-41-003,LCM 8 2 each 12V71 G.M. Diesel

Engines S/N 12VA5212795

S/N 12VA52793

Gentlemen:

The following conditions were noted and recorded during the disassembly, cleaning and inspecting of subject engine.

Engine S/N 12VA5212795

Cylinder block is cracked (See NDT Report). (1) each connecting rod bent. End plate on expansion tank eroded. Fuel lines damaged. Blower coupling assembly damaged. Crankshaft is worn beyond manufacture wear limits. Cam rollers worn and scored.

Transmission & P.T.O.

Forward clutch plates worn and scored. Bearings show heat discoloration Forward clutch springs broken.

Missing Parts Report

Generator, hydraulic pump (RPA).

Engine S/N 12VA52793

Cylinder block cracked (See NDT Report). Cam rollers worn and scored. Rocker arm shafts worn and scored. Rocker arms worn through hardened surface. Both valve covers damaged.

	Page #2		
	Continue	•	े. के कुत
		alikker	parts of
	Transmissio	on & P.T.O.	
•			springs broken.
	Missing Par	rts Reports	th's a
	Genera	ator, hydrauli	.c pump (RPA).
	: :		• · · · · · · · · · · · · · · · · · · ·
	Recommend	the following	list of material be repaired and or replaced
	Engine S/N	12VA5212795	
			CONNECTING ROD BENT
	1	5135756	CONNECTING ROD SEV
	1	5123741 5150344	CONNECTING ROD BEND PLATE EXPANSION TANK FRODER BLOWER COUPLING
	Transmissi	<u>on</u>	
	1	MA648	BALL BEARING
	1	MA647	ROLLER BEARING
	2 2	M2175B M2104	BALL BEARING BALL BEARING
	2	MA649	BALL BEARING
	1 2	M2475A MA293	ROLLER BEARING ROLLER BEARING
	ī	M2167	BALL BEARING
	Engine S/N	12VA52793	
	1 2		VALVE COVER
	2		VALVE COVER INST KIT

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Bay City Marine

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Continue	"Figure"		
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<u>Transmissi</u>	.on	·	
1 1 2 2 2 2 1 2. 1.	MA648 MA647 M2175B M2104 MA649 M2475A MA293 M2167	BALL BEARING BALL, ROLLER BALL BEARING	
		Very truly yours,	
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Bay City Marine

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ONTRACT NO.	VESSEL	BID/ 3-B	BCM INSPECTOR	SUPSHIPS SURVEYOR	SUBCONTRACTOR	PROGRESS REPORT	COMPLETION REPORT	GFM REPORT	REMARKS
1-81		3-B			·PRECISION	100%.	100%	100 %.	
2-81		3-B			NATIONAL PUMP	100%.	100%	100%.	→
3-81		BID			CLEANING DYN.	100%.	100 %.	100%.	
4-81		3-B			PC & E	100%.	100%.	100%.	
5-81		BID			PRECISION	100%.	100%.	100%.	
6-81		3-B			FRASER	100%.	100 %	100%.	* .
7-81		BID			PRECISION	100%.	100%.	100%.	
8-81		3 - B			PRECISION/CEM	100%	100%	100%.	
9-81		BID			A&E MACHINE	100%.	100%.	100%,	•
10-81		BID			BCM	100%	100%	100%.	,
11-81		3-B			FRASER	100%	100 To.	moon	*
12-81		3-B			FRASER	100%	100%.	100%.	
13-81		3 - B			FRASER	100%.	100%.	100	There actions
14-81		BID			CODE WELDING	85%	85%,		PENPINA GENERATOR TEST
15-81		BIID			всм	90 70	90%		
16-81		BID			BCM	100 To.	100%,	100	
17-81		3 - B			PRECISION	100%	100%	100	
18-81		BID			BCM	100%	100%	100	
19-81		3-B			FRASER - CODE A & E	90%,	90%.	ę	PENDING 3 STRIPPING PUMPS
20-81		3 - B			FRASER	100 To.	100%.	100	

AWARDED C IS

rs	TO	BCM	

CONTRACT NO.	VESSEL	BID/ 3-B	BCM INSPECTOR	SUPSHIPS SURVEYOR	SUBCONTRACTOR	PROGRESS REPORT	COMPLETION REPORT	GFM REPORT.	REMARKS
21-81		BID			. BCM	100%.	100 %.	100	Submitted 3/24/8)
22-81		3-B			PRECISION	100%.	100%.	100	
23-81		3-B 3-B			PRECISION	100%.	100%	100	
24-81		BID			BCM	100%	100%.	100	
25-81		BID			PRECISION/CEM	100%	100%	100	
26-81		BID			всм	100%	100%	100	
27-81		3-B			SPERRY GYRO	100%	100%	100	
28-81 F		3-B			CODE WELDING	100%	100%	100	
29-81		BID			BCM		HOLD -	_	HOLD START IN SEPT.
30-81		3-B			ACRO ELEC./ NATIONAL PUMF	100%	100%	·	our work anthonory 2-17-81
31-81		BID			BCM/A&E/FRYER NATIONAL PUMP	100%.	100%.	100	
32-81		3-B			FRASER	100%	100%	100	
33-81		3-B				100%	100%	160	
34-81		BID			BCM	100%.	100%	100	Submitted 2-23-81
35-81		BID			A & E MACHUNE	100	100	100	Frank has complified Report Submitted 95% 4/19/6
36-81		3-B			. & E/ PRECISION RPM	100%	100%		
37-81		BID			PRECISION/CEM	100%.	100 %.	100	
38-81		3-В			& DEAN	100%	100%	100	
39-81		3-B			A & E MAOH.	100%	100%	100	
140-81		3-B			FRASER (MIC-1) BOILER	100%	100%	100	
	^•								

'AWARDED C JTS TO BCM

CONTRACT NO.	VESSEL	BID/ 3-B	BCM INSPECTOR	SUPSHIPS SURVEYOR	SUBCONTRACTOR	PROGRESS REPORT	COMPLETION REPORT	GFM REPORT	REMARKS
41-81		BID			BCM - MSD	100%.	100%.	Open	
42-81		3-B			FRASER MIC-1 INS. SPEC.	10,0%	100%	100	
43-81		BID			A & E Machine	j00%	100 %	100	PIRT SUBMITTED 4/15/81 13
44-81		BID			PRECISION	100	100	LAST RI	PIRT SUBMITTED 4/10/81 13
45-81		BID			BCM MSD	100%	100%	Ng PROARE	SS REPORT NECETALD 3/198)
46-81		BID			BCM - MSD	84,			5/20/8/
47-81		BID			BCM	100	100	100	Submitted 100% 4/14
48-81		BID			A & E Mach.	100	100	100	Submille 100% 4/13
49-81		BID			A & E Mach.	100%.	100%.	Open	
50-81		3-B 3-B			ACRO & A&E	100	100		from A & E due in APRIL
51-81		3-B			PC & E	100%.	100%.	Open	
52-81		BID			A & E MACH.	91	90		5/11/81.
53-81		Bid			MSD BCM	. 90%	90,%	_	
54-81					BCM 0 MSD .	100%.	100%.	100	Lumilies 100% 4/21/81
55-81		BID			A&E ACRO	38			520'81
56-81		BID			BCM ;	100%.	100%	ajien	
57-81		BID			BCM	100%.	100%	100	
58-81		BID			PRECISION	100	100		`
59-81		BID			A&E MACHINE	100	100		
60-81		BID			BCM	37.		•	5720/8)
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ONTRACT NO.	VESSEL	BID/ 3-B	BCM INSPECTOR	SUPSHIPS SURVEYOR	SUBCONTRACTOR	PROGRESS REPORT	COMPLETION REPORT	GFM REPORT	REMARKS
61-81		BID			CAMAS BOILER	9) 70	90 Tr.		•
62-81		BID			A&E MACHINE	100 %.	100%.	overn	Limited 100% 4/2/81
63 <u>-</u> .81		BID			PRECISION	30.			5-20/8)
64-81		BID			Cleaning Dyn.	100%	100%	·	
65-81		BID			BCM	100%		3-11-1	Submitted 100 %. 5/12/8)
66-81		BID			A & E	100%	100%	100%	
67-81		BID			CODE WELDING	100	100	100%	
68-81		3-B			FRASER	100%	100%	100%	
¢69 - 81		BID			BCM	0.			
70-81		BID			BCM	43%			5/29/81
71-81									
72-81									
73 - 81									
	-							•	
	*, *,								-

BAY CITY MARINE QUALIFIED WELDERS & BRAZERS

STINE NAME b7C	BADGE	- HMA	TIG	MIG	S-B	PLATE	PIPE
		Carbon .			<u> </u>	х	
			Alum.			Х	
		9	tainless				Х
					CNA		х
		Carbon					Х
			Alum.			х	
		5	tainless				χ
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Bay City Marine

BAY CITY MARINE QUALIFIED WELDERS & BRAZERS

	NAME	b7C	BADGE	MMA	TIG	MIG	S-B	PLATE	PIPE
			I	Carbon			<u> </u>	Х	
					Alum.			Х	
					tainless				Х
							CNA		Х
				Carbon					Х
					Alum.			х	
				\$	tainless				Х
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				Carbon				Х	
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				Carbon		•		X	
								 	
							CNA		х
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				Carbon				X	
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		(29)							
		(30)							
. ~		(31)							
		(32)							
		(33)							
		(34)					***************************************		

men WEED Fig. 5 * POOLE BOATT s / LOT's LOG REPORT b6 IDR'S Contract No. 116-81 Vessel: LCM- 765, 783 DATE REMARKS SÚB ITEM SUBJECT MOD IDR DATE NO. NO. IDR NO. COU IN DARA PT VILL 1 10-7 CODE DT3.10 PT V OF IX ווע זק REPLACE NIPPLE (B) MOD- 3 APPGES 13 10.14 Bcm 3 11-3 REPLACE NIPPLES BOW RAMP WINCH NEED. NO COST TO 18 CODE 10-16

10-21 TECH MANUAL C-0-U NO COST TO GOV MANUF BEARINGS & INSTL 10-15 17 -)409 10-21 PT-MOD # 3 APPHES REQUEST TO UT STRUTS X 10-15 11-3 16 Bcm & BOTTOM PLATE UT REPAIR RUDDER & PROP MOD # 3 APPLIES 19 10-19 CODE 11-3 SHAFTING-THERMAL SDRAY REDAIR PRO SHAPTS
CONTRACTOR COU
REPAIR RUNDER 11-3 TARGET RUDDER & REMUE ZU 10-19 CODE 10-21 FLYNGES Flances & Post BLAST FUEL TANKS NO ADDIL WORK 32 10-19 BCW10.21 A UTHORIZED NO ADDIL WORK BLAST 4 PUEL TANKS ECM 31 10-19 10-21 AUTHORIZED EXPEDITE IDRIS MOD NEGOTIATION 33 10-20 TYM 10-21 NEW WORK NOT REPLACE AMP CARD **Z**dct 35 12-01 AUTHORIZED. 10.5:1 & TEST PROVIDE INEL FAN 36 10-Z1 PD S 10-21 ONETCH BOAT. REPL 2 ACCUMULATOR NPI 39 10-26 Required Deport 47 11-3 PDS REQUISED REALT ~18 11-3 PDS Nat Responsible for NPI 11-3 1)9 Rearies in Transmiss Not Repossible per crant-NPI 50 11-3 Shipt. NEW Relauters MANU = MOD 9 9 53 17-17 11-24 CUDE & Tues APPUE S

1411 Harding Avenue • National City, CA 92050 • (714) 474-8121

NG AVENUE . NATIONAL CITY, CA 92050 . (714) 474-8121 PERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

REPORT NO. 116-1 DATE SUBMITTED 10-7-81 CONTRACT NO. BCM 116-81 PLANNER/SURVEYOR

b6

INSPECTION DATE 10-6-81

b7C

RE: CW 0995-1

VIA: CODE # EUBJECT: USS

TREF.

1509-1D

SPEC. PKG. NO. SD 688-81

ART. NO. 583-41-003 MOD.

DURHAM LKA-14 #6765 & 6783

583-41-004

INSPECTION / DEFICIENCY REPORT

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS) VIII OF IX

Upon visual inspection, contractor noted that the lower support to skegs were cracked and has been temporarily repaired. Inspection also revealed cracks in strut supports.

CONTRACTOR'S RECOMMENDED ACTION

Issue contractor change order to NDT upper and lower portion of struts. Eight each boat (total of sixteen (16) areas). "V" out cracks and re-weld. NDE fin		•
welds.))	
· · · · · · · · · · · · · · · · · · ·	CONTRACTS	
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, and the second		
SIGNATURE OF ORIGINATOR		
URGENT		
REPLY REQUESTED BY:		
TO COMPLETE ARTICLE WITHIN AVAILABILITY PERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS	b6	
	b7C	
Covered in para: 3.10 of Bosis PART II		_
The same file in		
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INSPECTION / DEFICIENCY REPORT

b6

b7C

REPORT NO. 116-1 DATE SUBMITTED 10-7-81 CONTRACT NO. BCM 116-81 PLANNER/SURVEYOR INSPECTION DATE 10-6-81

NG AVENUE . NATIONAL CITY, CA 92050 . (714) 474-8121

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # SUBJECT: USS

REF.

1509-1D

SPEC. PKG. NO. SD 688-81

ART. NO. 583-41-003 MOD.

RE: CW 0995-1

583-41-004

DURHAM LKA-14 #6765 & 6783

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS) VIII OF IX

Upon visual inspection, contractor noted that the lower support to skegs were cracked and has been temporarily repaired. Inspection also revealed cracks in strut supports.

CONTRACTOR'S RECOMMENDED ACTION

Issue contractor change order to NDT upper and lower portion of struts. Eight areas each boat (total of sixteen (16) areas). "V" out cracks and re-weld. NDT finished welds.

	•	·	SIGNATURE SUPERVISOR OF SHIPBU		
			DATE		
UPERVISOR OF SHIPBUILDING REPRESEN	NTATIVES FINDINGS AND/OR RECC	OMMENDATIONS			
REPLY REQUESTED BY: O COMPLETE ARTICLE WITHIN AVAILABI			b7		_
	URGENT	Chidinaton	b6		_
		SIGNATURE OF ORIGINATOR		•	
	,				

REPORT NO. 116-2 DATE SUBMITTED 10-8-81

PLANNER/SURVEYOR

INSPECTION DATE 10-7-81

CW-1348-2

IDING AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

JPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-D SUBJECT: USS LCM-6 REF.

SPEC. PKG. NO. SD

ART. NO.

b6

b7C

688-81

583-41-002

MOD.

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

VISUAL INSPECTION REVEALS THE FOLLOWING:

- PORT RUDDER POST BADLY BENT
- 2.) PORT RUDDER BLADES BADLY DETERIORATED
- 3) STARBOARD RUDDER BADLY DETERIORATED

CONTRACTOR'S RECOMMENDED ACTION

ISSUE CONTRACTOR CHANGE ORDER TO RENEW PORT AND STARBOARD RUDDERS (BLADES AND STOCK). RUDDER STOCK TO BE STAINLESS STEEL.

		SIGNATURE OF ORIGINATOR	
TODAY DECLIECTED BY	URGENT		ь6 b7C
FIEPLY REQUESTED BY:TO COMPLETE ARTICLE WITH	N AVAILABILITY		B/C
PERVISOR OF SHIPBUILDIN	G REPRESENTATIVES FINDINGS AND/OR F	RECOMMENDATIONS	
		Principle and the second and the sec	DATE
	•		
•		SUPERVI	SIGNATURE SOR OF SHIPBUILDING REP.

Bay City Inc. Marional City, CA 92050 • (714) 474-8121

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136 INSPECTION / DEFICIENCY REPORT

REPORT NO. 116-13
DATE SUBMITTED 10-14-81
CONTRACT NO. BCM 116-81

PLANNER/SURVEYOR INSPECTION DATE 10-12-81

RE: BCM

b6 b7C

VIA: CODE # 1509-1D SUBJECT: USS

1 CM 0 12CL

SPEC. PKG. NO. SD

ART. NO.

MOD.

REF.

LCM-8 #765 & 783

688-81

583-41-003

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

1) Para 3.4.3 of PT VII does not cover bilge manifold nipples. Upon removal of bilge drain valves it was noted that the nipples were corroded and should be replaced.

CONTRACTOR'S RECOMMENDED ACTION

1.	Issue	contractor	a	change	order	to	remove	and	replace	each	2½"	Χ	4"	aluminim
nipp	les.										•• .			•

SIGNATURE O ORIGINATOR

PEPLY REQUESTED BY:

O COMPLETE ARTICLE WITHIN AVAILABILITY

SERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

MOD #3 APPLIES

//-3-8/ b6 b7C

DATE

SIGNATURE
SUPERVISOR OF SHIPBUILDING REP.



DING AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR,

REPORT NO. #13 DATE SUBMITTED 10-12-1 CONTRACT NO. BCM 116-81 PLANNER/SURVEYOR INSPECTION DATE 10-12-/

INSPECTION / DEFICIENCY REPORT

b6 b7C

SAN DIEGO, CA 92136 VIA: CODE # 1509 11

SPEC. PKG. NO. SD 688-81

ART. NO. 583-412003 MOD. 1 1004

SUBJECT: USS LCM-8 HULL 765 8 783

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

I.PARA 3.4.3 OF PT VII DOES NOT COVER BILGE MANIFOLD NIPPLES. UPON REMOVAL OF BILGE DRAIN VALVES IT WAS NOTED THAT THE NIPPLES WERE CORRODED AND SHOULD BE REPLACED.

CONTRACTOR'S RECOMMENDED ACTION

I. ISSUE CONTRACTOR A CHANGE ORDER TO REMOVE & REPLACE ZYZ" X 4" ALUMINUM NIPPLES

	SIGNATURE OF ORIGINATOR	ь6 . ъ7С
PLY REQUESTED BY: URGENT COMPLETE ARTICLE WITHIN AVAILABILITY UPERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMM	ENDATIONS	
	•	DATE
		SIGNATURE FOR OF SHIPBUILDING REP.

AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR,

VIA: CODE # 1509-1D

SAN DIEGO, CA 92136

SPEC. PKG. NO. SD

ART. NO.

REPORT NO. (116-16 DATE SUBMITTED

CONTRACT NO. BCM

PLANNER/SURVEYOR INSPECTION DATE

BCM

RE:

b6 b7C

LCM-8 #6765

688-81

583-41-003

MOD.

SUPERVISOR OF SHIPBUILDING REP.

INSPECTION / DEFICIENCY REPORT

10-15-81

116-81

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

During hull inspection design requested that contractor conduct UT on the port and stbd struts. And bottom plate from midship to frame #3 outboard strakes.

CONTRACTOR'S RECOMMENDED ACTION

1. Issue contractor a change order to perform ultra-sonic test on port and stbd struts and bottom plate (midships to frame #3 outboard strakes.)

SIGNATURE OF ORIGINATOR URGENT REPLY REQUESTED BY: TO COMPLETE ARTICLE WITHIN AVAILABILITY RERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS b6 MOD #3 APPLIES b7C

VENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

SPEC. PKG. NO. SD

DATE SUBMITTED
CONTRACT NO. BCM

REPORT NO.

PLANNER/SURVEYOR INSPECTION DATE

ART. NO.

b6 b7C

MOD.

SIGNATURE SUPERVISOR OF SHIPBUILDING REP.

VIA: CODE # SUBJECT: USS

REF.

LCN-8 \$676B

525-01

533-41-003 CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

INSPECTION / DEFICIENCY REPORT

1. During hull inspection design requested that contractor conduct UT on the port and stad struts. And bottom phito from midship to frame #3 outboard strakes.

CONTRACTOR'S RECOMMENDED ACTION

1. Issue centractor a change order to perform ultra-sonic test on port and atbd struts and bottem plate (midships to frame #3 outleard strakes.)

				SIGNATURE OF ORIGINATOR _	y	·	·	
	VRAINT							b 6
PLY REQUESTED BY:			•					b7C
ERVISOR OF SHIPBUILDING REPRESENTATI	VES FINDINGS	S AND/	OR RECO	MMENDATIO	ONS			
	•							
				,			DATE	
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1411 HARDING AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

ART. NO. MOD.

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INSPECTION / DEFICIENCY REPORT

SPEC. PKG. NO. SD 688-81

583-41-003

CW-0995-3

REPORT NO. 116-17 DATE SUBMITTED 10-15-81

PLANNER/SURVEYOR INSPECTION DATE

CONTRACT NO. BCM 116-81

F.

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

Contractor has been unable to locate Ryertex bearings for rudders before end of contract. Sources contacted:

1. King Bearing

2. Bearing Specialities

3. Bearing Unlimited

Six to eight weeks from factory.

CONTRACTOR'S RECOMMENDED ACTION

Issue change order to manufacture (4) four Ryertex type bearings or procure and install (4) cutless (Rubber type) bearings.

SIGNATURE C ORIGINATOR

DATE

SUPPRISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

SUITABLE SUBSTITUTE PUTHOR/FED AT

NO ADDITIONAL COST TO GOVERNMENT.

SUPERVISOR OF SHIPBUILDING REP.

	••
Code Welding & Fabrication Co., Inc. 426 West 15th Street National City, California 92050	SERIAL NO. CW 0.995-3 DATE SUBMITTED October 14, 1981 CONTRACT NO. BCM 116-81 PLANNER
TO: SUPERVISOR OF SHIPBUILDING CONVERSION & REPAIR, USN SAN DIEGO, CALIFORNIA VIA: SUPSHIP FIELD REPRESENTATIVE SUBJ: USS	Б7С IPN/PCN 20 HULL 74 CM 6765 74 CM 6783 I-81 ITEM NO. 583-14-3 MOD NO.
CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICAT	10N)
Contractor has been unable to loc	ate Ryertex bearings for rudders
before end of contract. Sources,	
2. Bearing Specialties	
3. Bearing Unlimited	
Six to eight weeks from factory. CONTRACTOR'S RECOMMENDED ACTION:	
	(4) four Ryertex type bearings of
procure and install (4) cutless (Rubber type) bearings.

SUPSHIP FIELD REPRESENTATIVE'S FINDINGS AND/OR RECOMMENDATIONS

REPLY REQUIRED BY 10/16/81 TO COMPLETE ITEM WITHIN AVAILABILITY

ь6 ь7с

NG AVENUE . NATIONAL CITY, CA 92050 . (714) 474-8121 O: SUPERVISOR OF SHIPBUILDING

CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D GUBJECT: USS

LCM-8 #6765 & 6783

SPEC. PKG. NO. SD

ART. NO.

REPORT NO. 116-18

PLANNER/SURVEYOR INSPECTION DATE

CW0995-2

RE:

DATE SUBMITTED 10-15-81 CONTRACT NO. BCM 116-81

MOD.

b6

b7C

BOW RAMP WINCH

688-81

583-41-003

SIGNATURE SUPERVISOR OF SHIPBUILDING REP.

INSPECTION / DEFICIENCY REPORT

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

Para 3.22 of Art. 583-41-003 tells contractor to use 2-C for repair and list of parts for bow ramp winch. This is a tech manual for Gearmatic winch. Existing winches are MARCO 6240 Model #W-4055. Contractors bid was based on repair of Gearmatic winches.

CONTRACTOR'S RECOMMENDED ACTION

		o direct cont ost for parts		proper tech	manual. Cover con	tractor
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REPLY REQU	URGENT		·	SIĞNATURE OF ORIGINATOR		
IZE/	 TO BE	ves findings and/of IVINSEIPS COST TO	RECOMMENDATION 0920-04 GOVERNM	6-8010	/0-21-8/ DATE	ь6 ь7С

TO BE REVIEWED BY Code Welding & Fabrication Co., Inc. CW 0995-2 SERIAL NO. . October 13, 1981 426 West 15th Street DATE SUBMITTED. BCM 116-81 National City, California 92050 CONTRACT NO. . . PLANNER b7C TO: SUPERVISOR OF SHIPBUILDING IPN/PCN CONVERSION & REPAIR, USN HULL LCM-8 SAN DIEGO, CALIFORNIA 74 CM 6783 VIA: SUPSHIP FIELD REPRESENTATIVE SUBJ: USS Durham LKA-114 SPEC. NO. SD-688-81 ITEM NO. 583-14-3... MOD NO. CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATION)

Bow Ramp Winch

Paragraph 3.22 of Art. 583-14-3 tells contractor to use 2-C for repair and list of parts for bow ramp winch. This is a tech manual for Gearmatic winch. Existing winches are MARCO 6240 Model #W-4055. Contractor's bid was based on repair of Gearmatic winches.

CONTRACTOR'S RECOMMENDED ACTION:

Issue Change Order to direct contractor to use proper tech manua Cover contractor for any additional cost for parts and labor.

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REPLY REQUIRED BY 10/15/81 TO COMPLETE ITEM WITHIN AVAILABILITY	
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SUPSHIP FIELD REPRESENTATIVE'S FINDINGS AND/OR RECOMMENDATIONS

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AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121 SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR,

INSPECTION / DEFICIENCY REPORT

REPORT NO. 116-19 DATE SUBMITTED 10-19-81 CONTRACT NO. BCM 116-81 PLANNER/SURVEYOR **INSPECTION DATE** 10-15-81

b6 `` b7C

RE: BCM

SAN DIEGO, CA 92136

VIA: CODE # 1509-1D SUBJECT: USS 1.CM-1

LCM-8 #765 & 783

SPEC. PKG. NO. SD

ART. NO. 583-41-003 MOD.

XXXXX 688-81

583-41-004

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

- Contractor has accomplished para 3.23 of PT VIII the following descrepancies were XXX noted:
 - Propulsion shafting is worn in way of backing gland and cutless bearing
 - b. Rudder shafting is worn and shows pipe wrench and hammer marks in bearing area.

CONTRACTOR'S RECOMMENDED ACTION

 Issue a change order to repair rudder and propulsion shafting using thermal spray process on bearing and packing gland areas IAW is MILSTD 1687 (SH) of 24 NOV 80 (para 6-6.2.1)

SIGNATURE OF ORIGINATOR b6 REPLY REQUESTED BY: URGENT b7C TO COMPLETE ARTICLE WITHIN AVAILABILITY RVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

MOD #3 APPLIES

SUPERVISOR OF SHIPBUILDING REP.



411 HARDING AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

INSPECTION	17	DEFICIENCY	REPORT
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REPORT NO. #19	
DATE SUBMITTED 10~19-/	
CONTRACT NO. BCM //6-8/	_
PLANNER/SURVEYOR] _{b6}
NSPECTION DATE	1 D0

SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

688-81

VIA: CODE # 1509. 1 D

SPEC. PKG. NO. SD 668-81

ART. NO. 58 3. 41-003 MOD.

SIGNATURE SUPERVISOR OF SHIPBUILDING REP.

SUBJECT: USS LCM-8- HULL 765-783

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

- THE FOLLOWING DESCREPANCIES WERE NOTED
 - FI PROPULSION SHAPTING IS WORN IN WAY OF BACKING GLAND AND CUTLESS BEARING ARED.
 - IL RUDDER SHAFTING IS WORN AND SHOWS PIPE WRENCH AND HAMMER MARKS IN BEARING ARED

CONTRACTOR'S RECOMMENDED ACTION

PROPULSION SHAPTING USING THERMAL SPRAY

PROCESS ON BEARING AND PACKING GLAND AREAS

IN ACCORDANCE WITH MIL STO 1687 (SH) OF

"ZHNOU 1980 (PARA 6-6.2.1)

		-		
•	7.7 4	SIGNATURE C ORIGINATOR	ь6 ь7с	
REPLY REQUESTED BY: O COMPLETE ARTICLE WITHIN AVAILABILITY OPERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR I	DECOMMENDATIO	NS.		
PERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR I	RECOMMENDATIO		DATE	
			·	

Code Welding & Fabrication Co., Inc.

426 West 15th Street National City, California 92050 SERIAL NO. CW 0995-6 DATE SUBMITTED October 14, 1981 CONTRACT NO. BCM 116-81 PLANNER

TO: SUPERVISOR OF SHIPBUILDING CONVERSION & REPAIR, USN SAN DIEGO, CALIFORNIA

IPN/PCN... 20 74 CM 6765 74 CM 6783

VIA: SUPSHIP FIELD REPRESENTATIVE

41-003

SUBJ: USS Durham LKA-114 Spec. No. SD-688-81 ITEM NO. 583-14-3 MOD NO. =

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATION)

PROPULSION SHAFTING - RUDDER SHAFTING

- Propulsion shafting is worn in way of packing gland and cutless bearing area.
- Rudder shafting is worn and shows pipe wrench and hammer marks in bearing area.

12 ana 3.23.

CONTRACTOR'S RECOMMENDED ACTION:

Issue Change Order to repair rudder and propulsion shafting using thermal spray process on bearing and packing gland areas.

Enclosure 1 MIL-STD-1687 (SH) 24 November 1980 Paragraphs 6 through 6.2.1

. b7С

October 17, 1981 REPLY REQUIRED BY TO COMPLETE ITEM WITHIN AVAILABILITY

SUPSHIP FIELD REPRESENTATIVE'S FINDINGS AND/OR RECOMMENDATIONS

SIGNATURE OF SUPSHIP REPRESENTATIVE

MIL-STD-1687(SH) 24 November 1980 (See Section 7)

MILITARY STANDARD

THERMAL SPRAY PROCESSES FOR NAVAL SHIP MACHINERY AND ORDNANCE APPLICATIONS



FSC MFFP

MIL-STD-1687(SH) 24 November 1980

- 5.3.8.1 Care should be taken in any machining or grinding operation in order to avoid damage to the coating. Improper techniques during the finishing operation could result in pull-out of particles, thus producing a severely pitted surface or in heat checking. It is essential that the sprayed particles be clearly sheared and not pulled from the surface as a result of the finishing operation.
- 5.3,8.2 All masking materials shall be removed prior to surface finishing. Finished dimensions shall be as required by the acquisition specification or drawing.
- 5.3.8.3 Generally, wet grinding is recommended over dry grinding, provided the proper wheel is used. Wheels with coarse grain and low bond strength shall be used to grind sprayed coatings to prevent loading the wheel. When a coolant is used, it shall contain a rust inhibitor and be kept clean and free of foreign matter. The grinding wheel shall not remain immersed in the coolant as it will become unbalanced due to the absorption of moisture.
- 5.3.9 Safety precautions. Safety practices contained in AW,S C2.1 shall be followed.
 - 6. THERMAL SPRAY APPLICATIONS
 - 5.1 General.
- 6.1.1 Thermal spray coatings can be applied to build up worn or mis-machined parts and to improve abrasion resistance. They are not intended to fill gouges or similar localized damage without building up the entire area. Thermal spray deposits do not restore properties such as tensile strength or resistance to fatigue stresses.
- 6.1.2 Information contained in this section is presented for the purpose of assisting in the selection of a coating which would be appropriate for the intended application and also suitable to the capabilities of the performing facility. Selection shall be made from the presented listings in table I whenever possible; however, thermal spray applications and coatings are not limited to these listings.
- ' 6.1.3 Selection of one of the listed applications/coatings does not eliminate the need for the performance qualification tests required by this standard.
 - 6.2 Approved applications.
- 6.2.1 Machinery. Thermal spray coatings have been approved by NAVSEA for several generic applications. Case by case approval is not needed for use of thermal spraying in the applications listed below. Process instructions (that is, spray process, spray equipment, spray

MIL-STD-1687(SH) 24 November 1980

parameters, coating materials, sealers, and finishing) used for these applications are limited to those which have been approved by NAVSEA for various components of machinery equipment, except propulsion shafts:

- (a) Repair of seal (packing) areas of shafts used in oil and fresh water systems to obtain original dimensions and finish.
- (b) Repair of bearing interference fit areas of shafts to restore original dimensions and finish (except for motors and generators where chromium plating is permissible.
- (c) Build up of pump shaft wear ring sleeves to original dimensions.
- (d) Repair of miscellaneous static fit areas to restore original dimensions, finish and alignment.
- 6.2.2 Ordnance. Ordnance equipment approval is limited to static applications for restoring desired dimensions or for shimming to maintain interchangeability of components, except for hydraulic or pneumatic applications, where a sealer is required.
- 6.3 Proposed applications. Applications that are not listed in 6.2.1 and 6.2.2 require specific NAVSEA approval. This approval will be based on the results of a laboratory or service test to determine the adequacy of the coating in the proposed application. The test plan shall include a process instruction to cover the preparation of the test samples or parts, and the method of conducting the test for coordination with the NAVSEA technical agent responsible for the equipment.

7. SUPERSESSION

7.1 This standard includes the requirements of NAVSHIPS 0919-000-6010, "Metallizing of Shafts and Similar Objects", 31 August 1966.

Preparing activity:
Navy - SH
(Project MFFP-N149)

Code Welding & Fabrication Co., Inc.

426 West 15th Street National City, California 92050 SERIAL NO. CW-0995-4

DATE SUBMITTED October: 14, 1981

CONTRACT NO. BCM 116-81

PLANNER

TO: SUPERVISOR OF SHIPBUILDING CONVERSION & REPAIR, USN

SAN DIEGO, CALIFORNIA

VIA: SUPSHIP FIELD REPRESENTATIVE

IPN/PCN 20 HULL 74 СМ 6765

SUBJ: USS Durham LKA-114 SPEC. NO. SD -688-81 ITEM NO. 583-14-3. MOD NO.

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATION)

Required "As found" reports

- A. Tail Shaft
- B. Rudder Shaft

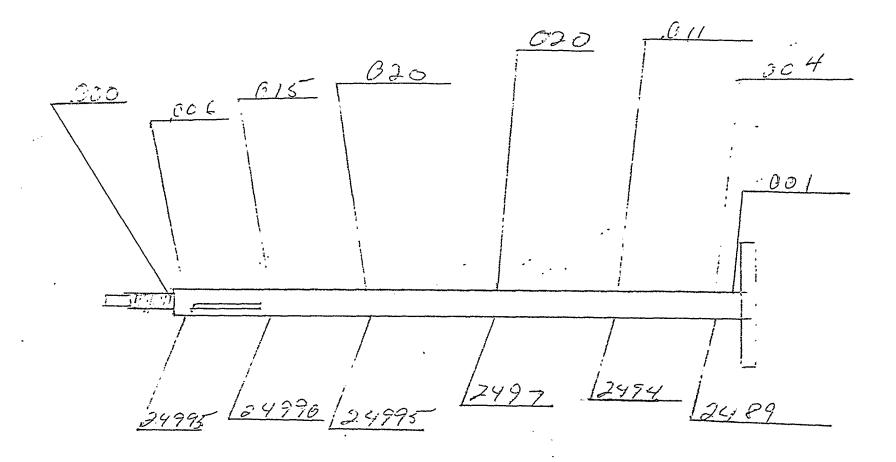
CONTRACTOR'S RECOMMENDED ACTION:

Required "As found" report

REPLY REQUIRED BY
TO COMPLETE ITEM WITHIN AVAILABILITY

SUPSHIP FIELD REPRESENTATIVE'S

SUPSHIP FIELD REPRESENTATIVE'S FINDINGS AND/OR RECOMMENDATIONS



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Code Welding & Fabrication Co., Inc. 426 West 15th Street National City, California 92050	SERIAL NO. CW-0995-5 DATE SUBMITTED OCTOBER -14, 1981 CONTRACT NO. BCM 116-81 PLANNER	
TO: SUPERVISOR OF SHIPBUILDING CONVERSION & REPAIR, USN SAN DIEGO, CALIFORNIA VIA: SUPSHIP FIELD REPRESENTATIVE	1PN; PCN 20 HULL 74 CM 6783	
SUBJ: USS_Durham LKA-114 SPEC. NO. SD-6	188-81 - ITEM NO. 583-14-3 - MOD NO.	The state of the s
Required "As found" reports A. Tail Shaft B. Rudder Shaft CONTRACTOR'S RECOMMENDED ACTION: Required "As found" reports	para 7. 3,23	b6 b7C
REPLY REQUIRED BY TO COMPLETE ITEM WITHIN AVAILABILITY SUPSHIP FIELD REPRESENTATIVE'S FINDINGS AND/OR RECOMMENDATIONS	. ,	, n

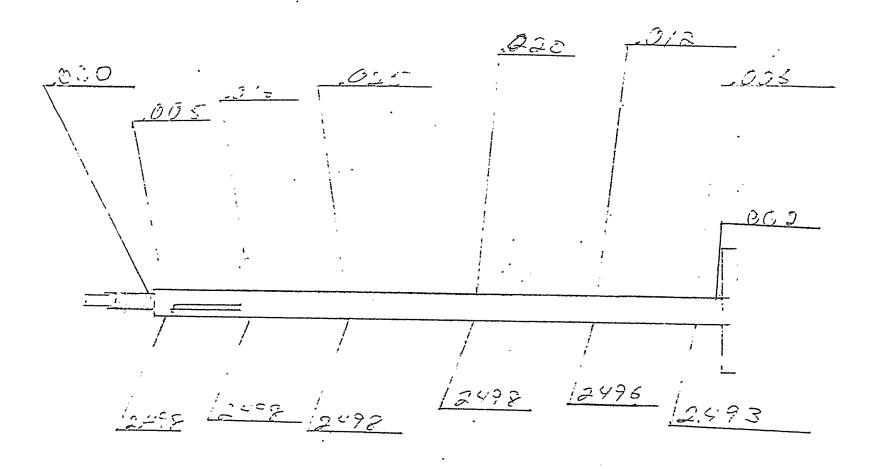
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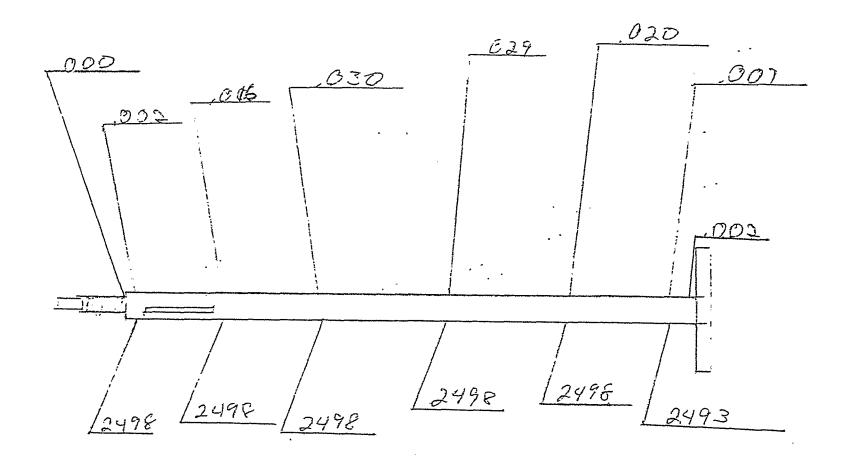
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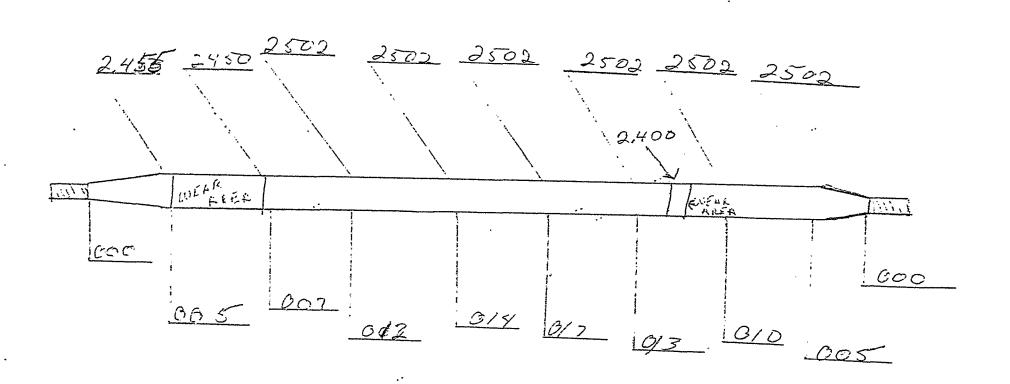
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AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR,

SUBJECT: USS 1509-1D

SAN DIEGO, CA 92136

SPEC. PKG. NO. SD

ART. NO.

REPORT NO. 116-20

PLANNER/SURVEYOR

INSPECTION DATE

DATE SUBMITTED 10-19-81 CONTRACT NO. BCM 116-1

MOD.

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INSPECTION / DEFICIENCY REPORT

LCM-8 #765 * 783

688-81

583-41-003

CW 0995-7

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

1. Contractor has accomplished para 3.18.1 of PT VIII. Rudders are badly XXXX pitted and eroded and : flanges are badly pitted and bent.

CONTRACTOR'S RECOMMENDED ACTION

1. Issue contractor a change order to target rudders and remove the flanges and replace with new weld buildup; lower rudder post and remachine.

SIGNATURE OF ORIGINATOR		
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URGENT

REPLY REQUESTED BY: . TO COMPLETE ARTICLE WITHIN AVAILABILITY

ERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

CONTRACTOR COVERED IN PARA. 3.19

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SUPERVISOR OF SHIPBUILDING REP.

Code Welding & Fabrication Co., Inc.

426 West 15th Street National City, California 92050

CW 0995-7 SERIAL NO. -10/15/81 DATE SUBMITTED BCM 116-81 CONTRACT NO. PLANNER

TO: SUPERVISOR OF SHIPBUILDING CONVERSION & REPAIR, USN

SAN DIEGO, CALIFORNIA

20 74 CM 6765 74 CM 6783

VIA: SUPSHIP FIELD REPRESENTATIVE

50B): USS Durham LKA-114 SEC NO SD-688-81 11LM NO. 583-74-3

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CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATION)

Contractor has noted that rudders are badly pitted and eroded and flanges are badly pitted and bent.

114-1 Port

114-1 Starboard

114-2 Port

Starboard Police 114-2

CONTRACTOR'S RECOMMENDED ACTION:

- Issue contractor a Change Order to target rudder and remove the flanges and replace with new.
- Weld buildup; lower rudder post and remachine. . В.

b6 b7C

REPLY REQUIRED BY As soon as possible TO COMPLETE THEM WITHIN AVAILABILITY

SIGNATURE OF ORIGINATOR, TITLE & AUTH.

SUPSTILE FLELO REPRESENTATIVE'S FINDINGS AND/OR RECOMMENDATIONS

Code	Welding & Fabrication Co., Inc. 426 West 15th Street National City, California 92050	SERIAL NO. CW 0995-8 DATE SUBMITTED October 15-, 1982 CONTRACT NO. BCM 116-81 PLANNER	<u>l</u>	1
VIA:	SUPERVISOR OF SHIPBUILDING CONVERSION & REPAIR, USN SAN DIEGO, CALIFORNIA SUPSHIP FIELD REPRESENTATIVE JE USS Durham LKA-114 SPEC. NO. SD-68	1PN/PCN 20 HULL 74 CM 6765 74 CM 6783		
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CON	DITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATION)	TION)		
	 Required "as found" report 	ct of rudders		
		70:		
CON.	TRACTOR'S RECOMMENDED ACTION:			
	Required "as found" repor	t.	b6 b7C	
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REPLY TO CO	REQUIRED BY OMPLETE ITEM WITHIN AVAILABILITY			
	HP FIELD REPRESENTATIVE'S NGS AND/OR RECOMMENDATIONS			

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Bay City Inc. Marine 1019 W. LAUREL STRE He

INSPECTION / DEFICIENCY REPORT

DATE SUBMITTED 10-19-81
CONTRACT NO. BCM
PLANNER/SURVEYOR
INSPECTION DATE

b6 b7C

JREL STREET, SAN DIEGO, CA 92101 • (714) 235-8367

SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D

SPEC. PKG. NO. SD

ART. NO.

RW

RE:

MOD.

SUBJECT: USS REF. FUI

FUEL LCM-8's

688-81

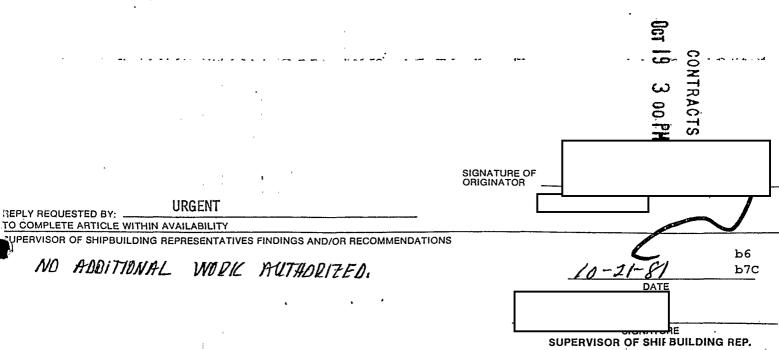
583-41-003

TANK PRESVTN CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

THE SPECIFICATIONS DO NOT REQUIRE CONTRACTOR TO ABRASIVE BLAST FUEL TANKS ON LCM-8.

CONTRACTOR'S RECOMMENDED ACTION

ISSUE CONTRACTOR A CHANGE ORDER TO ABRASIVE BLAST INSIDE AND OUTSIDE (4) FUEL TANKS ON 2 LCM-8's.





T. SAN DIEGO, CA 92101 • (714) 235-8367

D: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA:	CODE #	1
	HOT: HEE	4

1509-10

uss Durham

SPEC. PKG. NO. SD

ART. NO.

REPORT NO. 115~33

PLANNER/SURVEYOR

INSPECTION DATE

DATE SUBMITTED 10-20-31 CONTRACT NO. BCM 116-3

MOD

b6

b7C

INSPECTION / DEFICIENCY REPORT

688-81

ALL

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

AS OF THIS DATE, MANE IDR'S HAVE NOT BEEN ANSWERED AND NAWY PHASES OF THE JOB ARE HELD UP PENDING A DECISION FROM SUPSHIP. THIS TYPE OF INDECISION WILL DEFINITELY HAVE AN LUPACT ON COMPLETING THE CONTRACT ON TIME.

CONTRACTOR'S RECOMMENDED ACTION

EXPEDITE THE ANSWERING OF IDN'S ASAP.

SIGNATURE OF ORIGINATOR	 ь6 ь7С
	 ·

REPLY REQUESTED BY: URGENT

COMPLETE ARTICLE WITHIN AVAILABILITY

RVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

SIGNATURE

DATE

SUPERVISOR OF SHIPBUILDING REP.

STREET, SAN DIEGO, CA 92101 • (714) 235-8367

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

SPEC. PKG. NO. SD

ART. NO.

REPORT NO. 116-32 DATE SUBMITTED10-19-81 CONTRACT NO. BCM 116-81

PLANNER/SURVEYOR

INSPECTION DATE

RE: BCM

MOD.

b6 b7C

INSPECTION / DEFICIENCY REPORT

VIA: CODE # 1509-1D SUBJECT: USS 1 CM-S LCM-8 REF.

688-81

583-41-003

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

The specifications do not require contractor to abrasive blast fuel tanks.

CONTRACTOR'S RECOMMENDED ACTION

Issue change order to abrasive blast (4) fuel tanks.

SIGNATURE OF ORIGINATOR b6

REPLY REQUESTED BY: . TO COMPLETE ARTICLE WITHIN AVAILABILITY

UPERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

URGENT

ND ADDITIONAL WORK AUTHORITED.

b7C SIGNATURE SUPERVISOR OF SHIPBUILDING REP. ?

Abrasive Blasting . Coatings

3923 PACIFIC HIGHWAY • SAN DIEGO, CALIFORNIA 92110 • (714) 297-3705

P.O. BOX 82152 • SAN DIEGO, CA 92138 Contractor's License 236815

	INSPECTION/DEFICIENCY REPORT	Serial No
TO:	Supervisor of Shipbuilding	Date 15 SEPT 81
	Conversion and Repair	Contr. No
	11 ND, USN San Diego, CA 92136	SUPSHIP'S Planner
	·	SHIP LCM-8'S
		•
VIA:	CONTRACTOR: SWM	
	ATTENTION:	
	SUBJECT: FUEL TANK PRESERVATION	SPEC. NO
	ARTICLE MOD	DATE OF INSPECTION
	REFERENCE:	
	CONDITIONS FOUND (NOT COVERED IN ORIGINAL, SPE	·

THE SPECIFICATIONS DO NOT REQUIRE CONTRACTOR

FUEL TWKS ON LCM-B. TO ABRASIUE

CONTRACTOR'S RECOMMENDED ACTION

AUTHORIZE CONTRACTOR TO ABRASIVE BLAST 4 FUEL TANKS ON Z LCM'83, PROVIDE FUNDS THRU MODIFICATION OF CONTRACT.

b6 b7C Bay City inc. Marine 1019 W. LAUREL STREET, SAN DIEGO, CA 92101 • (714) 235-8367

Ho

INSPECTION / DEFICIENCY REPORT

REPORT NO. 116-33
DATE SUBMITTED 10-20-81
CONTRACT NO. BCM 116-81
PLANNER/SURVEYOR
INSPECTION DATE

ь6 ь7с

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D

SPEC. PKG. NO. SD

ART. NO.

MOD.

BUBJECT: USS USS DURHAM

688-81

ALL

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

AS OF THIS DATE, MANY IDR'S HAVE NOT BEEN ANSWERED AND MANY PHASES OF THE JOB ARE HELD UP PENDING A DECISION FROM SUPSHIP. THIS TYPE OF INDECISION WILL DEFINITELY HAVE AN IMPACT ON COMPLETING THE CONTRACT ON TIME.

CONTRACTOR'S RECOMMENDED ACTION

EXPEDITE THE ANSWERING OF IDR'S ASAP.

ONTRACTS

3 10 PH 811

SIGNATURE OF ORIGINATOR

FRANK HEDDY

REPLY REQUESTED BY: _____

TO COMPLETE ARTICLE WITHIN AVAILABILITY

RVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

NO IDR IS HALAGEBRED UNANSWERED EXCEPT DIVES REQUIRING MOD. NEGOTIATION. 10-21-81

R.E. Cottle

SIGNATURE SUPERVISOR OF SHIPBUILDING REP.

EL STREET, SAN DIEGO, CA 92101 • (714) 235-8367

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D

SPEC. PKG. NO. SD

ART. NO.

REPORT NO. . 116-35

CONTRACT NO. BCM PLANNER/SURVEYOR

INSPECTION DATE

DATE SUBMITTED 10-21-81

b6 b7C

RE: **PDS**

MOD.

INSPECTION / DEFICIENCY REPORT

10-20-81

SUBJECT: USS LCM-8 #67.65

688-81

583-41-003

REF. PT VI, PARA 3.9

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

The rudder servo amplifier card is beyond economical repair.

CONTRACTOR'S RECOMMENDED ACTION

replace

A change order be issued to contractor to KANTAXX amplifier card and test.

	- .	 		· · · · · · · · · · · · · · · · · · ·	CONTRACTS	
EPLY REQUESTED BY:	URGENT		SIGNATURE OF ORIGINATOR			
DEW wor Busic .	G REPRESENTATIVES			/0 -2 DAT	21~8/ re	

Serial No. Date Submitted Contract No. SUPSHIPS Planner San Diego, California VIA: SUPSHIPS Field Inspector SUBJ: USS DURMAM Spec No: (250-8). Art No: Mod No: OR Hull No. of (boats) LEA JIM Reference: CM-R o VERMAUL Date of Inspection 19/20/8/ Reference: CM-R o VERMAUL Date of Inspection 19/20/8/ Conditions found (not covered in original specification) REF. PAR. 3.9 % of UI I. THE RUDDER SERVO Amplifier CARD II. THE RUDDER SERVO Amplifier CARD Contractor's recommended action A CHANCE ORDER BE ISSUED TO CONTRACTOR TO REPLACE Amplifier CARD LITER CARD LIT	INSPECTION/DEFICIENCY REPORT	. 06
Contractor's recommended action ACMANCE ORDER DESCRIPTION CONTRACTOR TO SUPSHIPS Field Inspector CONTRACTOR TO SUPSHIPS Planner BOR PDS SUPSHIPS Planner SUPSHIPS Planner Bor PDS SUPSHIPS Date Received from Contractor Date Received from Contractor		Serial No: 35
SUPSHIPS Planner Supervisor of Shipbuilding, Conversion and Repair, USN San Diego, California VIA: SUPSHIPS Field Inspector SUBJ: USS OR Hull No. of (boats) Reference: Con-T o Verhau Nut. 1765 Conditions found (not covered in original specification) REF. PAR. 3.9 of 0 T UI 1. THE RUDGER SERVO Amplifier CARD 1. THE RUDGER SERVO Amplifier CARD Contractor's recommended action A CHARLE ORDER SERVO Amplifier CARD CONTRACTOR TO REPLACE Amplifier CARD I TEST.		
TO: Supervisor of Shipbuilding, Conversion and Repair, USN San Diego, California VIA: SUPSHIPS Field Inspector SUBJ: USS DURHAM Spec No: 68-8/Art No: Mod No: OR Hull No. of (boats) Reference: Con-Y OVERHAUL Date of Inspection 10/20/3/ Reference: Con-Y OVERHAUL Date of Inspection 10/20/3/ REF. PAR. 3,9 % OT UI 1. THE RUDDER SERVO Amplified CARD 1. THE RUDDER SERVO Amplified CARD 2. THE RUDDER SERVO Amplified CARD Contractor's recommended action A CHANCE ORDER BE 155UED TO CONTRACTOR TO REPLACE Amplified CARD LIFER CAR		Contract No:
TO: Supervisor of Shipbuilding, Conversion and Repair, USN San Diego, California VIA: SUPSHIPS Field Inspector SUBJ: USS		DU
San Diego, California VIA: SUPSHIPS Field Inspector SUBJ: USS DURHAM Spec No: 688-8/ Art No:		KER PDS 67C
VIA: SUPSHIPS Field Inspector SUBJ: USS DURHAM Spec No. 688-8/ Art No: Mod No: OR Hull No. of (boats) LRA 1146 Reference: CM-8 OVERHAUL Date of Inspection 10/20/8/ REF. PAR. 3.9 of DT VI 1. THE RUDDER SERVO AMPLIFIER CARD 1. THE RUDDER SERVO AMPLIFIER CARD 2. THE RUDDER SERVO AMPLIFIER CARD CONTRACTOR'S recommended action A CHANCE ORDER BE 155 UED TO CONTRACTOR TO REPLACE AMPLIFIER CARD VIEST.		
Reference: CM-8 overHaul Date of Inspection 10/20/8/ Reference: CM-8 overHaul Date of Inspection 10/20/8/ ANAL 1765 Conditions found (not covered in original specification) REF. PAR, 3,9 of DT VI 1. THE RUDDER SERVO AMPLIFIER CARD 1. THE RUDDER SERVO AMPLIFIER CARD 2. SEYOND ECONOMICAL REPAIR Contractor's recommended action A CHANGE ORDER BE 155UED TO CONTRACTOR TO REPLACE AMPLIFIER CARD Y TEST. SUPSHIPS Field Inspector Date Received from Contractor	VIA: SUPSHIPS Field Inspector	and the second
Reference: CM-8 OVERHAUL Date of Inspection 10/20/8/ Reference: CM-8 OVERHAUL Date of Inspection 10/20/8/ ANLL 1765 Conditions found (not covered in original specification) REF. PAR, 3,9 % OT UI 1. THE RUDDER SERVO AMPLIFIER CARD 1. THE RUDDER SERVO AMPLIFIER CARD 2. SEVOND ECONOMICAL REPAIR Contractor's recommended action A CHANGE ORDER BE 155UED TO CONTRACTOR TO REPLACE AMPLIFIER CARD LITERATION SUPSHIPS Field Inspector Date Received from Contractor	SUBI: USS DURHAM Spec No: 688-	8/ Art No: Mod No:
Conditions found (not covered in original specification) REF. PAR. 3.9 of DT VI 1. THE RUDDER SERVO AMPLIFIER CARD 1. THE RUDDER SERVO AMPLIFIER CARD REPAIR Contractor's recommended action A CHANGE ORDER BE 155 UED TO CONTRACTOR TO REPLACE AMPLIFIER CARD Y TEST. SUPSHIPS Field Inspector Date Received from Contractor	OR Hull No. of (boats)	
Conditions found (not covered in original specification) REF. PAR. 3.9 of DT VI 1. THE RUDDER SERVO AMPLIFIER CARD 1. THE RUDDER SERVO AMPLIFIER CARD REPAIR Contractor's recommended action A CHANCE ORDER BE ISSUED TO CONTRACTOR TO REPLACE AMPLIFIER CARD Y TEST. SUPSHIPS Field Inspector Date Received from Contractor	Reference: 200-8 OVERHAUL Date of In	nspection 10/20/8/
REF. PAR. 3.9 of DT UI 1. THE RUDDER SERVO AMPLIFIER CARD 1. THE RUDDER SERVO AMPLIFIER CARD BEYOND ECONOMICAL REPAIR Contractor's recommended action A CHANGE ORDER BE ISSUED TO CONTRACTOR TO REPLACE AMPLIFIER CARD Y TEST. SUPSHIPS Field Inspector Date Received from Contractor	HILL 6765	
Contractor's recommended action A CHANCE ORDER BE ISSUED TO CONTRACTOR TO REPLACE AMPLIFIER CARD Y TEST. SUPSHIPS Field Inspector Date Received from Contractor		
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Contractor's recommended action A CHANCE ORDER BE ISSUED TO CONTRACTOR TO REPLACE AMPLIFIE CARO Y TEST. SUPSHIPS Field Inspector Date Received from Contractor	BELLOND ECONOMICAL E.	EPAIR
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A CHANCE ORDER SE ISSUES O CONTRACTOR TO REPLACE AMPLIFIE CARO Y TEST. SUPSHIPS Field Inspector Date Received from Contractor	Contractor's recommended action	
CONTRACTOR TO REPLACE AMPLIFICATION CARD VIEST. SUPSHIPS Field Inspector Date Received from Contractor	OF HOUSE BE	5 155 UED 70
CARD V 7537. Date Received from Contractors		
SUPSHIPS Field Inspector Date Received from Contractor	CONTRACTOR TO REPLA	ce Amplified
SUPSHIPS Field Inspector Date Received from Contractor		
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mango and of recommendations	YUNGUNG TUNI Turan da su	Date Deschool from C. Australia
	•	Date Received from Contractor
	•	Date Received from Contractor
Signature of SUPSHIPS Representative	•	

Date Submitted_____

TREET, SAN DIEGO, CA 92101 • (714) 235-8367 O: SUPERVISOR OF SHIPBUILDING

REPORT NO. 116-360

DATE SUBMITTED 10-21-81 CONTRACT NO. BCM __ 116-81

INSPECTION / DEFICIENCY REPORT

PLANNER/SURVEYOR INSPECTION DATE 10-20-81

b6 b7C

RE: PDS

CONVERSION AND REPAIR, SAN DIEGO, CA 92136 VIA: CODE # 1509-1D SPEC, PKG, NO. SD

ART. NO.

MOD.

LCM-8 #6765 & 6783 REF. PT VI, PARA 3.3

SUBJECT: USS

688-81

583-41-004

conditions found (not covered in original specifications)

1. Spec calls out the removal of 2 fans per coat. Only one fan was installed per boat.

CONTRACTOR'S RECOMMENDED ACTION

A change order be issued to contractor to provide and mount one new fan on each boat with a 6' cord and plug.

SIGNATURE OF ORIGINATOR URGENT REPLY REQUESTED BY: . TO COMPLETE ARTICLE WITHIN AVAILABILITY

SUPERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

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INSPECTION/DEFICIENCY REPORT	. A.
DEPT TO THE PROPERTY OF THE PR	Serial No: 34
	Date Submitted
	Contract No:
	Contract No.
	SYNCHING Planner
	SUPSHIPS Planner b6
TO: Supervisor of Shipbuilding, Conversion and Repair, USN	REF. PDS b7C
San Diego, California	•
VIA: SUPSHIPS Field Inspector	583 -41 may
SUBJ: USS DURHAM Spec No: 688 OR Hull No. of (boats)	5 63-44-003
SUBJ: USS URHAM Spec No: 688	8/ Art No: Mod No:
• • • • • • • • • • • • • • • • • • • •	
Reference: LCM. 8 HULL 6763 Date of I	nspection
Conditions found (not covered in original specification)	~ D+1
Conditions found (not covered in original specification) REF. PAR 3.3 FANS. 1 1. Spec CALLS our	THE REMOVEL
1. Spec CALLS OUT	
OF 2 FANS PER BOAT. O.	
INSTALLED PER BOAT.	.
,	•
	•
	•
Contractor's recommended action	A second
A CHANGE ORDER	BE-1550EO
CONTRACTOR TO PROVIDE	+ MOUNTONE
NEW FAN ON EACH BOAT	WITH A 6 CORD
+ Plus.	
•	
AVIDALINA DI LA LA	
SUPSHIPS Field Inspector	Date Received from Contractor
Findings and/or Recommendations	

Signature of SUPSHIPS Representative

Date Submitted_



LCM-8

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE #

REF.

SPEC. PKG. NO. SD SUBJECT: USS 1509-12

ART. NO.

RE: NPI

b6 b7C

583-41-003

REPORT NO.

PLANNER/SURVEYOR INSPECTION DATE

CONTRACT NO. BCM 10226-81

MOD.

SUPERVISOR OF SHIPBUILDING REP.

INSPECTION / DEFICIENCY REPORT

688-81 CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

The fellowing conditions were noted and recorded during the disassembly, cleaning and inspecting of the (8) each accumulators. (1) each accumulator type ACB-30071108 5/H 6MBB96 is eroded at the seal erea.

CONTRACTOR'S RECOMMENDED ACTION

issue the contractor to replace with new one each accumulator.

		SIGNATURE OF	٠.	
REPLY REQUESTED BY:	URGENT	ORIGINATOR		
	REPRESENTATIVES FINDINGS AND/OR R	ECOMMENDATIONS		
			DATE	
			SIGNATURE	,



1019 W. LAUREL STREET. SAN DIEGO: CA 92101 • (714) 235-8367

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE #

1509-10

SPEC. PKG. NO. SD

ART. NO.

REPORT NO. 116-47 DATE SUBMITTED CONTRACT NO. BCM

PLANNER/SURVEYOR INSPECTION DATE

MOD.

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INSPECTION / DEFICIENCY REPORT

116-81

SUBJECT: USS

USS DURNAM

683-81

583-41-002

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

REF PARA 3.12 of 009-17 FYB2, 12 Sept 80

1) Two (2) alternators: There were no defects found that were not govered by the basic specifications.

CONTRACTOR'S RECOMMENDED ACTION

REPORT ONLY

3-8.1.1

SIGNATURE OF ORIGINATOR	
· · · · · · · · · · · · · · · · · · ·	
·	•
	<u> </u>

OMPLETE ARTICLE WITHIN AVAILABILITY

REPLY REQUESTED BY:

ERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

DATE



LTO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE #

SPEC. PKG. NO. SD

600-81

ART. NO.

REPORT,NO.

DATE SUBMITTED 48

PLANNER/SURVEYOR

INSPECTION DATE

MOD.

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SUBJECT: USS 1509-10 hayand ser

583-41-004

CONTRACT NO. BCM 11-3-61

INSPECTION / DEFICIENCY REPORT

PARA 3.12 # 109-17 CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

1) Two (2) alternators: There wer a no defects found that were not govered by basic specifications.

CONTRACTOR'S RECOMMENDED ACTION

REPORT ONLY

REPLY REQUESTED BY:

ERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOM	MENDATIONS			
LY REQUESTED BY: OMPLETE ARTICLE WITHIN AVAILABILITY		,	<u> </u>	
	SIGNATURE OF ORIGINATOR	· · · · · · · · · · · · · · · · · · ·		

SIGNATURE SUPERVISOR OF SHIPBUILDING REP.



TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR; SAN DIEGO, CA 92136

VIA: CODE # 1509-10 SUBJECT: USS

LCH-B USS DURHAM

SPEC. PKG. NO. SD 683-81

ART. NO.

REPORT NO.

PLANNER/SURVEYOR INSPECTION DATE

DATE SUBMITTED CONTRACT NO BCM

b6

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SIGNATURE SUPERVISOR OF SHIPBUILDING REP.

INSPECTION / DEFICIENCY REPORT

11-3-81

583-61-003 & 004

REF.

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

CONTRACTOR WAS DIRECTED ON 10-30-81 BY SUPSHIP TO INSTALL ORIGINAL BEARINGS IN ALL FOUR MARINE TRANSBISSIONS.

CONTRACTOR WILL NOT BE RESPONSIBLE FOR TRANSMISSION FAILURE DUE TO THIS DECISION.

CONTRACTOR'S RECOMMENDED ACTION

INFORMATION ONLY

			· .	•			•
		1.			SIGNATURE OF ORIGINATOR	,	
EPLY REQUESTED	DV						
OMPLETE ARTI	CLE WITHIN		/ES FINDINGS	AND/OR RECOMMEN	DATIONS	<u> </u>	
57 ENVIOUN 5. 5						•	•
		•	•				DATE
				· .* .*			



SHIPBUILDING ON AND REPAIR,

VIA: CODE # SUBJECT: USS

1509-10 MSS DURHAM SPEC. PKG. NO. SD

ART. NO.

REPORT NO. 116-50 DATE SUBMITTED

PLANNER/SURVEYOR

INSPECTION DATE

RE: BCM

CONTRACT NO. BCM

MOD.

b6

b7C

INSPECTION / DEFICIENCY REPORT

583-41-003 A004

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

CONTRACTOR HAS BEEN VERBALLY DIRECTED BY SUPSHIP ON 10-30-81 TO INSTALL THE REJECTED CRANKSHAFT IN ENGINE S/N 12VAS21279S AS REPORTED ON LOT-10 (ATTACHED) CONTRACTOR WILL NOT BE RESPONSIBLE FOR ENGINE FAILURE DUE TO THIS DECISION.

CONTRACTOR'S RECOMMENDED ACTION

INFORMATION ONLY

SIGNATURE SUPERVISOR OF SHIPBUILDING REP.

		SIGNATURE C	ne.
		ORIGINATOR	- Artic
			`.
EPLY REQUESTED BY:	ABILITY		
ERVISOR OF SHIPBUILDING REPRE		RECOMMENDATIONS	
	•	•	
			DATE

Bay Sity inc. Name of the street, San Diego, CA 92101 • (714) 235-8367

O: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D SUBJECT: USS 1 CM-6

SUBJECT: USS LCM-6 REF.

SPEC. PKG. NO. SD 688-81 ART. NO. 583-41-002 MOD.

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INSPECTION / DEFICIENCY REPORT

116-81

PT VI

REPORT NO. 116-38

CONTRACT NO. BCM

PLANNER/SURVEYOR

INSPECTION DATE

RE: BCM

DATE SUBMITTED 10-23-81

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

BATTERY BOX IS NON-EXISTING. REFERENCES GIVEN DO NOT SHOW BATTERY BOX CONSTRUCTION.

CONTRACTOR'S RECOMMENDED ACTION

SUPPLY CONTRACTOR WITH CORRECT REFERENCE TO CONSTRUCT BATTERY BOX.

	Section 1. The section of the sectio	lobes see , e s te		CONTRACTS
4	÷		SIGNATURE C ORIGINATOR	
REPLY REQUESTED BY:				
Correct of with the	representatives findings an		- -	//-3-8/ DATE
344-3**** - + · · ·		and the second second second second		27

(et NG AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121 JPERVISOR OF SHIPBUILDING

INSPECTION / DEFICIENCY REPORT

REPORT NO. 116-11 DATE SUBMITTED 10-14-81 CONTRACT NO. BCM 116-81 PLANNER/SURVEYOR

INSPECTION DATE 10-12-81

b6 b7C

CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D

SUBJECT: USS LCM-6 #6761

SPÈC. PKG. NO. SD

ART. NO.

MOD.

688-81

583-41-002

CW1348-11

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

RUBBER FENDERING

UPON INPSECTION. IT WAS NOTED THAT THE SHACKLES THAT HOLD THE LOWER CHAIN OF THE RUBBER FENDERING ARE MISSING. TOTAL OF TWELVE (12). SIX PORT AND SIX STARBOARD.

CONTRACTOR'S RECOMMENDED ACTION

ISSUE CHANGE ORDER TO REPLACE SHACKLES WITH PAD-EYES, TOTAL OF TWELVE (12). PROCURE SHACKLES TO ATTACH CHAIN TO PAD-EYES. TOTAL OF TWELVE (12) SHACKLES.

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•		SIGNATURE ORIGINATOF	
EPLY REQUESTED BY:	URGENT		
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SOCOVICOD OF CHIDDLIII DINI	C DEDDESENTATIVES SINDINGS AND/O	D DECOMMENDATIONS	

Covered in myd # 1

11-3-81

Bay City inc.
Marine
1411 HARDING AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

REPORT NO. 116-6
DATE SUBMITTED 10-13-81
CONTRACT NO. BCM 116-81
PLANNER/SURVEYOR
INSPECTION DATE 10-12-81
RE: CW1348-6

INSPECTION / DEFICIENCY REPORT

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TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

SPEC. PKG. NO. SD

ART. NO.

MOD.

VIA: CODE # 1509-1D SUBJECT: USS LCM-6

688-81

583-41-002

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

BY DIRECTION OF SUPSHIPS, THE FIRE EXTINGUISHER BRACKET WAS REMOVED FROM BULKHEAD. BRACKET IS RUSTED AWAY AND BROKEN.

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CONTRACTOR'S RECOMMENDED ACTION

ISSUE CHNGE ORDER TO REMOVE BRACKET, REPLACE WITH NEW AND REINSTALL.

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				UTRACTS
····	* * * * * * * * * * * * * * * * * * *	ကြောင်းကြီး ကြောက်သည် သော မေးသောလိုင်း သည် (၁) မေးသော (၁)	and the special party of the s	<u> </u>
		SIGNATURE OI ORIGINATOR		
REPLY REQUESTED BY: FO COMPLETE ARTICLE WI	ASAP THIN AVAILABILITY			
ERVISOR OF SHIPBUILD	DING REPRESENTATIVES FINDINGS AND/OR RECOM	MENDATIONS	,	1-2. 5-1

AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121 SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR,

INSPECTION / DEFICIENCY REPORT

REPORT NO. 116-7 DATE SUBMITTED 10-13-81 CONTRACT NO. BCM PLANNER/SURVEYOR INSPECTION DATE

b6 10-12-81 b7C

RE:

CW1348-7

VIA: CODE # 1509-1D SUBJECT: USS I CM_6

SPEC. PKG. NO. SD

ART. NO.

MOD.

LCM-6

SAN DIEGO, CA 92136

688-81

583-41-002

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS) IX

UPON INSPECTION IT WAS NOTED THAT THE BOW RAMP GASKET WAS DAMAGED AND PARTLY MISSING.

CONTRACTOR'S RECOMMENDED ACTION

ISSUE CHANGE ORDER TO REMOVE GASKET AND RETAINERS, WELD BUILDUP AND GRIND GASKET SEALING SURFACE, SANDBLAST AND PAINT SEALING AREAS. REPLACE WITH NEW THE GASKET AND RETAINERS, CHALK AND HOSE TEST BOW RAMP GASKET.

SIGNATURE O ORIGINATOR ASAP REPLY REQUESTED BY: . TO COMPLETE ARTICLE WITHIN AVAILABILITY

ERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

Covered by med #1



TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D SUBJECT: USS

LCM-6

SPEC. PKG. NO. SD .

ART. NO.

PLANNER/SURVEYOR **INSPECTION DATE**

RE: CW 1348-17

MOD.

b6

b7C

INSPECTION / DEFICIENCY REPORT

116 - 81

10 - 15 - 81

REPORT NO. XXX XXXXXX 116-24

688-81

583-41-002

PT VIII

DATE SUBMITTED 10-19-81 CONTRACT NO. BCM 116-8

STEERING SYSTEM CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

- 1. Helm bore is deteriorated beyond repair due to dissimilar metals. Heim is aluminum and shaft is steel.
- Helm shaft is twisted and dented.
- 3. Chain sprocket is worn.

CONTRACTOR'S RECOMMENDED ACTION

SIGNATURE OF ORIGINATOR

Tssue	cha	nge	order	to:

- Procure and install a new helm.
- Procure and install new xxx helm shaft.
- Procure and install new chain sprocket.

URGENT

REPLY REQUESTED BY: _ O COMPLETE ARTICLE WITHIN AVAILABILITY

ERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

MOD #2 APPLIES TO

NO ADDITIONAL WORK MUTHORIZED ON PARA #3



TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D SPEC. PKG. NO. SD 688-81 SUBJECT: USS LCM-8 765 & 783

ART. NO. 583-41-004 MOD.

INSPECTION / DEFICIENCY REPORT

11/16/81

116-81

SIGNATURE
SUPERVISOR OF SHIPBUILDING REP.

b6

b7C

116-51

PT VIII

REPORT NO.

DATE SUBMITTED

CONTRACT NO. BCM

PLANNER/SURVEYOR INSPECTION DATE

CW 00995-11,12,13

REF.

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

- 1. Item 583-41-004 PT VIII, para 3.22 directs contractor to remove the propellers, but does not indicate re-installation.
 - 2. Upon completion of para 3.19, it became evident that the thrust support bracket is not in line with the rudder bearing and tube.
 - 3. Para 3.20.1 directs contractor to make adjustments to the rudders. Inspection reveals that the steering arms are badly bent in the adjustment areas, and contractor feels that they will break if straightening is attempted.

CONTRACTOR'S RECOMMENDED ACTION

- 1. Request SUPSHIP direction.
- 2. Issue contractor a change order to relocate support bracket for true alignment, total of four (4) brackets.
- 3. Issue contractor a change order to replace the threaded areas.

	SIGNATURE O ORIGINATOR	
REPLY REQUESTED BY: URGENT!!!!		
TO COMPLETE ARTICLE WITHIN AVAILABILITY		
SUPERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOM	MENDATIONS	-
		DATE



DING AVENUE . NATIONAL CITY, CA 92050 . (714) 474-8121

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-10

REF.

SUBJECT: USS LCM-8 #6765 & 6783

SPEC. PKG. NO. SD

688-81

ART. NO.

REPORT NO. 116-53

PLANNER/SURVEYOR

RE: CW 1040-1

INSPECTION DATE

DATE SUBMITTED 11-17-81 CONTRACT NO. BCM 116-81

583-41-004

MOD.

b6

b7C

INSPECTION / DEFICIENCY REPORT

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

S.W. COOLING AND DRAIN VALVES

Para 3.4.3 - Contractors attempt to complete work outlined in this para revealed the following: Valves are aluminum with stainless steel trim. The seat retainer is aluminum and the seat, stainless steel. Due to corrosion and electrolysis, the seat and retainer have become as one. The seats are replaceable.

CONTRACTOR'S RECOMMENDED ACTION

Issue contractor a change order to manufacture new retainers from stainless steel material and install two (2) new seats. Upon completions of repairs, hydrostatically test valves.

	URGENT	SIGNATURE O ORIGINATOR	
EPLY REQUESTED BY:O COMPLETE ARTICLE WITHIN			
	REPRESENTATIVES FINDINGS AND/OR RECO	MMENDATIONS	

VENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

RC:	CH	1040-1

b6 b7C

VIA: CODE # 1509-10

SPEC, PKG, NO. SD

ART. NO.

REPORT NO. 110-53

PLANNER/SURVEYOR INSPECTION DATE

CONTRACT NO. BCM

MOD.

SIGNATURE SUPERVISOR OF SHIPBUILDING REP.

INSPECTION / DEFICIENCY REPORT

SUBJECT: USS LCH-8 76765 & 6703

688-81

583-41-104

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

S.W. COOLONG AND DRAIN VALVES

Fara 3.4.3 - Contractors attempt to complete work outlined in this para revealed the following: Valves are alwainen with stainless steel trim. The seat retainer is aluminum and the seat, stainless steel. Due to corresion and electrolysis, the seat and retainer have become as one. The seats are replaceable.

CONTRACTOR'S RECOMMENDED ACTION

Issue contractor a change order to manufacture non redainers from stainless steel caterial and install two (2) new seats. Upon completions of repairs, hydrociatically test valves.

	ł			
			SIGNATURE OF ORIGINATOR	
NEDLY OCCUPATED DV.	URGENT			
REPLY REQUESTED BY:	VAILABILITY	ID OR RECOMMEND	ATIONS	
PER VISOR OF SHIPBUILDING RI	PHESENTATIVES FINDINGS AN	DON RECOMMEND	WIIONO .	
PER VISOR OF SHIPBUILDING RE	PHESENTATIVES FINDINGS AN	, .	ATIONS .	

Code Welding & Fabrication Co., Inc. 426 West 15th Street National City, California 92050	SERIAL NO DATE SUBMITTED CONTRACT NO PLANNER	DOM: 116 01	
TO: SUPERVISOR OF SHIPBUILDING CONVERSION & REPAIR, USN SAN DIEGO, CALIFORNIA VIA: SUPSHIP FIELD REPRESENTATIVE SUBJ: USS DURHAM (LKA-114) SPEC. NO. SD. 6	IPN/PCN HULL 88-81 ITEM NO	21 74 CM 6765 74 CM 6783 . Pt. VIII of 1	, b6 b7c
CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFIC	CATION)		
Paragraph 3.20.1 directs cont	1		:
rudders. Inspection reveals bent in the adjustment areas,		_	eak :
if straightening is attempted CONTRACTOR'S RECOMMENDED ACTION:	₫ .	•	
Issue contractor a change ord	der to replace	the threaded areas.	
REPLY REQUIRED BY TO COMPLETE ITEM WITHIN AVAILABILITY			
SUPSHIP FIELD REPRESENTATIVE'S FINDINGS AND/OR RECOMMENDATIONS			
	SIGNATURE OF	SUPSHIP REPRESENTATIVE	•

DATE

Code	Welding & Fabrication Co., Inc. 426 West 15th Street National City, California 92050	DATE SUBMITTED	.CW_0995-13 11/12/81 BCM_116-81	ь6 ь7с
VIA:	SUPERVISOR OF SHIPBUILDING CONVERSION & REPAIR, USN SAN DIEGO, CALIFORNIA SUPSHIP FIELD REPRESENTATIVE SU: USSDURHAM(LKA=114) SPEC. NOSD_68	. IPN/PCN HULL 88-81 ITEM NO.	21 74 CM 6783 74 CM 6765 Pt VIII of 1 -583-41-004 MOD NO.	[X
CON	IDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICA	ATION)		
•	THRUST SUPPORT BRACKETS (RUDDER)	<u>)</u>	•	
	Upon completion of Paragraph 3.1	19, it became	evident that the	
	thrust support bracket is not in	n line with rud	lder bearing and tube.	•
	•			
CON	TRACTOR'S RECOMMENDED ACTION:			
	Issue contractor a change order	to relocate su	pport bracket	
•	for true alignment total. Total	l - four (4) br	ackets	
				•
	,3.			
			,	
	•			
REPL TO	LY REQUIRED BY 11/16/81 COMPLETE ITEM WITHIN AVAILABILITY			
	SHIP FIELD REPRESENTATIVE'S DINGS AND/OR RECOMMENDATIONS			
	,			
	•			
	••	SIGNATURE OF	SUPSHIP REPRESENTATIVE	<i>'</i>
		DATE		

ode Welding & Fabrication Co., Inc. 426 West 15th Street National City, California 92050	SERIAL NO DATE SUBMITTED CONTRACT NO PLANNER	DOM 116 01	b6
TO: SUPERVISOR OF SHIPBUILDING CONVERSION & REPAIR, USN SAN DIEGO, CALIFORNIA VIA: SUPSHIP FIELD REPRESENTATIVE SUBJ: USS DURHAM, LKA-114) SPEC. NO. SD	IPN/PCN HULL 688-81 ITEM NO	21 74 CM 6783 74 CM 6765 583-41-004 MOD NO.	ь7c
CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFI	CATION)	والمراق	
• PROPELLERS .	•	•	
Paragraph 3.22 directs contr	actor to remove t	the propellers, bu	ıt
does not indicate reinstalla	tion.	·	
•		`~ {	
CONTRACTOR'S RECOMMENDED ACTION:		••	•
Issue contractor a change or	der to install pr	opellers/	
*			
REPLY REQUIRED BY 11/16/81 TO COMPLETE ITEM WITHIN AVAILABILITY			
SUPSHIP FIELD REPRESENTATIVE'S FINDINGS AND/OR RECOMMENDATIONS	1	dayan ayuna yayun gaman danan dan	
·		UPSHIP REPRESENTATIVE	. ,

DATE

PRICE PROPOSAL
13 ND SUPSHIP SEATTLE 4265/1 (REV. 2-81)

SEATTLE WASHINGTON 98115

PAGE	1	QF	PAGES
-81			SERIAL NO.

	1 3231122, WASHINGTON 30113	PAGE	1 QF PAGE
SS USS DURHAM LKA.	-114 (SMALL BOATS)	BCM 116-81	SERIAL NO.
COAR NO: 16-589		ITEM NO: 583-41-	- 003
		PCN: 20	
		. PLANNER:	ь6 b7С
TITLE: LCM & OVERHAU	IL - DURHAM LEA-	114	

1, SCOPE: 10R # 51,53

2. REFERENCES:

· CA) STANDARD ITEMS CB) NAUSEA S90 BG-HP-STM-000/CH-245

3. REOUIREMENTS:

3.1 INSTALL PROPEELERS. (ZEA)

3. Z ALIGN SUPPORT BRACKET, (2 EA.)

3.3 REPLACE THREADED AREAS ON STEERING ARMS.

3.4 PRIME AND PAINT NEW AIND DISTRUBED AREDS.

3.5 REPAIR COOLING AND DRAIN VALUES, (4 EA)

DEPARTMENT OF THE NAVY SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, USN.

PRICE PROPOSAL 13 ND SUPSHIP SEATTLE 4265/1 (REV. 2-81)

SEATTLE, WASHINGTON 98115

PAGE 1 OF PAGES

SHIP USS DURHAM LKA-114 (SMALL BOATS)

COAR NO: 6 - 587

ITEM NO: 583-41-004

PCN: 21

PLANNER: b6
b7c

TITLE: LCM-8 OUERHAUL - DURHAM LKA-114

1. SCOPE: IDR #51

2. REFERENCES:

(B) STANDARD ITEMS (B) NIAUSEA & 9086-HP-STM-000/CH-245

3, REPUIREMENTS

3.1 INSTALL PROPELLERS ZEA.

3.2 ALIGN SUPPORT BRACKETS 2 EA.

3.3. REPLACE THREADED AREAS ON STEERING AKMS, 3.4 PRIME AND PAINT NEW AND DISTRUBED AREAS.

MEC CONVERSION AND REPAIR, USN. PRICE PROPOSAL 13 ND SUPSHIP SEATTLE 4265/1 (REV. 281) SEATTLE, WASHINGTON 98115 PAGE 1 OF **PAGES** SHIP USS DURHAM LIGA-114 บรร ITEM NO: 583-41-003 COAR NO: 16-584 PCN: 20 PLANNER: TITLE: USS DURHAMI LKA-114 (SMAIL DUATS) b7C), SCOPE: IDR # 13, 16, 19,20 2. REFERENCES (A) REFER TO BASIC PART 8 OF 9 PAGE 1. 3. REQUIRENTS M 3. I REPLACE BILGE MINIVIFOLD NIPPLES. M 3.2 CONDUCT LIT ON STRUTS AND BOTTOM PLATING. DE3,3 REPAIR PROPULSION SHAFTS! ES. 4 REPAIR RUDDER FLANGES AND POST. DES. S. CLEAN PRIME AIND DAINT NEW AIND DISTRUBED SURFACES TO MATCH SURROUNDING AREAS.

PRICE PROPOSAL	CONVERSION AND REPAIR, USN.	KEC 10/28	1600
13 ND SUPSHIP SEATTLE 4205/1 (REV. 2-81)	SEATTLE, WASHINGTON 98115	PAGE 1 OF	PAGES
USS USS DURHAM LEA-1	14 (SMALL DOATS)	BCM 116-8 1 0	12/4
COAR NO: 16-584		ITEM NO: 583-41-0	04
		PCN: 21 ·	
		PLANNER:	b6 b7C
TITLE: DURHAM LKA-114	(SMALL BUATS)		
1 ann Ta a # 19	2 0		
SCOPE: JOR # 19, 2			
REFERENCES	. ra naci-l	F. D	•
(A) REFER TO PART &		- BASIC	
REQUIREMENTS			
DE 3.1 REPAIR 2 EA. P.	RO PULSION SHAP	TS.	
E 3.2. REPAIR RUDOL	ERS FLANGES AN	U Past.	
DE S. 3. PRIME , PAINT,	NEW AND DISTRUB	EI) SURFACES TO	
MATCH. SURROU	NDING AREAS.		
	· · · · · · · · · · · · · · · · · · ·		\ \frac{1}{2}
			Ì
	**		'

			CALL TO BE

PÁICE PROPOSÁL (B.NO SUPSHIP SEATTLE SOULL SE)	
S. USS DOKHAM	
COAR NO: 76-516-4	
TITLE:	
	BEST COPY
7. SCOPE: ///	
CA 1 57207	
3. RAGOIR. J.	
2.2 KEPLACE AND STATE	
3.4 PRIME	
Above work will be completed by the Above work will require Job Order complete to	
The undersigned agrees that the above-specific	
AUTHORIZED CONTRACTOR REPRESENT	
ONTRACTOR The undersigned certifies that the LDC Tob	
SHIP SUR	b
nature	
VORK SCOPE APPROVED - AUTHORIZED GOVERNS	

ICE PROPOSAL ND SUPSHIP BEATT	
	Acres 100 March
COAR NO: 7/6-51/6	565-91-cog
COAR NO.	
	BULBEAND & S. F
TITLE: 01962 AVA	
	BEST
	COPY
SCOPE:	
The Contract of the Contract o	
() NAUSER ELLE	
3. The Golden Balling St. Comments of the Comm	
3.1 11136 1	
THE MOST PE	
The state of the s	
	100 1887 TO SE
Above work will be completed by current Job Order complete. Above work will require Job Order completion date extended to	The second secon
The undersigned agrees that the above-specified work	
isruptions involved in this work and will be completed	
UTHORIZED CONTRACTOR REPRESENTATIVE	
	jugarā (m. 1905.) Pilotopas (m. 1905.)
	*.
ONTRACTOR	
he undersigned certifies that the above job, as described:	
HIP SURVEYOR	ъ6
Pete 7	b7C
ORK SCOPE APPROVED - AUTHORIZED GOVERNME	A 12
Signature	9310

IDR's / LOT's LOG REPORT

Bay City Marine

شد آ	Warner .			·			······································	
		ract No.			LOT'S Ve	essel:	LCM'	765 , 783
	LOR NO.	DATE	SUB IDR	ITEM NO.	SUBJECT	MOD NO.	DATE	REMARKS
	ط	10-12-1		583-41	REQUEST FORMAL HULL INSPECTION	X	1 <u>V</u> -12	765 RC VD & NOTED 1300-10-14-1
	1	10-2-1		1.	DAR "B" 502 FOR 17	X		
	2.	10-2-1		11	SCHEDULE OF EVENOT REPORTS	X	10-8	RECVD 10-8-1 CODE 1509 10
	3	10-2-1		4.5	PERSONNEL AUTHOR TO RRE- FORM INSPECTEST	X		
	Z R-1	10-9-1		į l	RESUBMITTED SCHEDULE AF EVENTS	X		
	8	10-12-1		13	PCD FOR FLUSH OF HVD STEERING SYS	X		
	10	10-15-1	NPI	, (AS FOUND REPORT			
	, 11	10-15-1	MPI	11	AS FOUND REPURI			
				1 (AS FOUND REPORT			
				11	AS FOUND REPORT			
	All	116-20	Ben	, (5906 10-22-1	X	10-21	TIME 8 DAYE POCE BANGEL
	15	10.58	BcM	1 /	NDT - REPORT	X	10-58	i .
	17	10-29	BCM	11	SURGE TEST	X	10-30	RECUD & NOTED
	19	11-6	PDS),	BALADOCE REPORTS ALTERNAIDE RUTORS	X	. ,	
	<u> </u>	11-6	PDS	1.	BAL REPORT ALTERNA ROTORS	X		
-								
L)							

1411 Harding Avenue • National City, CA 92050 • (714) 474-8121

LETTER OF	TRANSMITTAL	lo. <u>NOT 1</u>
FROM: BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050 TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119	Contract: 115-81 Vessel: LC1-8 Item: 583-41 PART IX of IX Spec. S/D 538-81	_Date: <u>10-2-63</u> _Hull: <u>765 & 783</u> _Mod
San Diego, California 92136 Attn: Code # 1509.10	Reference:	ъ6 ъ7С
☐ Required Report(s) ☐ Schedule of Events ☐ Excess Material ☐ Supships S/) 4500/2 ☐ Drawing(s) ☐ Test Memo ☐ J.O. Exception(s) Completed ☐	Enclosure(s):	CONTRACTS SEP 32 2 50 PH '81
Comments: Enclosure (1) forwarded in accordance wit	th para 3.4.2 of item Part II	of 1X
BAY CITY MARINE, INC. Signature ate: 10-2-81	Supships Signature:	Date:

11ND_SUPSHIPSD_4550/1(REV. 5-81)(TRIAL)	INVENTORY S	CHEDULE - P	ETROLEUM	PRODUCTS	DISPOSAL (Re	ef: DAR "B" 502)	DATE:
USS Sushan 965-183	CONTRACTOR Buy Lel	Marin	<i>ح</i> و	SUB-CONTRAC		contract	NO. L.O.T. NO.
TYPE PETROLEUM PRODUCT REMOVED FROM TANK NO.	PUMPED TO TANK/ BARGE/TRUCK NO.	DATE REMOVED FROM SHIP	 	TAPE READING	ONUMBER OF GALLONS	REMAI	RKS
	BAROLY INCA NO.	7 KG/7 G1711	START	FINISH	REMOVED		
1 Dissel 583-41		9-30-81			Ø	Leantes le	un emply
2 Diesel 1/11	_				Ø	When se	and Was
3 Diesel 58341-					Ø	to lee	taken lang
4 Dies of					Ø	Contrace	ton of
5							•
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8						-	en a ca
9					•		
10						***	
11							
12							•
13							
14					-		-
15						-	ntro cata e un tamba de tarte de trada e un de trada e
ABOVE INVENTORY HAS BEEN VERIFIED ACCURATE	DATE: SUPSHIP SURVEYOR				DATE: PRIME CONTRAC	тоя _	ь6 ь7с
NO FUEL/OIL WAS REMOVED FOR ABOVE SHIP & CONTRACT	OR SHIP'S REPRESENT	ATIVE	SIGNATURE/RA	NK/RATE			
CMA FUEL ANNEX SIGNATURE			. 			DATE:	•
		SUPSHIPSD 5	O2A DATE	D 22 MAY	1981		

BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050 (714) 474-8121 TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119 San Diego, California 92136 Attn: Code # 1509.1D Sy Required Report(s) Schedule of Events Excess Material Supships S/D 4500/2 Drawing(s) Test Memo J.O. Exception(s) Completed Comments: Crelowure (4) & famoush in accourance willy para 3.42 Of them Part II of 1x.	LETTER O	F TRANSMITTAL No
Attn: Code # 150 9.1 b Required Report(s) Enclosure(s): Schedule of Events (1) DAR "B" 50 2 Excess Material Supships S/D 4500/2 Drawing(s) Test Memo J.O. Exception(s) Completed Comments:	BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050 (714) 474-8121 TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119	Vessel: LCM -8 Hull: 765 & 78. Item: 583.41 Part 1 × Mod. Spec. S/D 688-81
Schedule of Events Excess Material Supships S/D 4500/2 Drawing(s) Test Memo J.O. Exception(s) Completed Comments:	Attn: Code # 1509.15	b6
Comments:	☐ Schedule of Events ☐ Excess Material ☐ Supships S/D 4500/2 ☐ Drawing(s) ☐ Test Memo	
	Comments:	
	Of eller Part II of 1X	
	Of ellem Part II of 1X	in accordance with para 3.4 c.
BAY CITY MARINE, INC. Supships	BAY CITY MARINE, INC.	

LETTER OF	TRANSMITTAL HU No.	#2
BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050	Contract: 116-81 D	
TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119 San Diego, California 92136 Attn: Code #	Item: 042-01 N Spec. S/D 688-81 Reference:	_
☐ Required Report(s) ☐ Schedule of Events ☐ Excess Material ☐ Supships S/) 4500/2 ☐ Drawing(s) ☐ Test Memo ☐ J.O. Exception(s) Completed ☐	Enclosure(s): SCHEDULE OF EVENT REPORTS 1. PRODUCTION SCHEDULE 2. MANPOWER LOADING CURVE 3. SUBCONTRACTORS	CONTRACTS SEP 32 2 52 PH'81
Comments: RECEIVED 10/8/81 COOD DUE TO LACK OF ENTERES LS LOST EN SYSTEM.		ь6 ь7с
BAY CITY MARINE, INC. Signature: Date: 10-2-81	Supships Signature	Date & SK

W . walker in

LETTER O	F TRANSMITTAL No.
FROM: BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050 TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119 San Diego, California 92136 Attn: Code #	Contract:
☐ Required Report(s) ☐ Schedule of Events ☐ Excess Material ☐ Supships S/ > 4500/2 ☐ Drawing(s) ☐ Test Memo ☐ J.O. Exception(s) Completed ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐	Enclosure(s): SCHEEULE OF EVERT PAPERTS 1. PRODUCTION SCHEEULS 2. MARROLER LOADTYS CURVE 3. SUBLA TENATORY:
BAY CITY MARINE, INC. Signature:Date:	Supships Signature: Date:

LETTER OF	TRANSMITTAL No. #2
TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119 San Diego, California 92136 Attn: Code #	Contract: //6-8/ Date:
☐ Required Report(s) Schedule of Events ☐ Excess Material ☐ Supships S/D 4500/2 ☐ Drawing(s) ☐ Test Memo ☐ J.O. Exception(s) Completed ☐	Enclosure(s): SCHEPULE OF EVENT REPORTS 1. PRODUCTION SCHEDULE 2. MAN POWER LOADING CURVE 3. SUBCONTRACTORS
Comments:	

Supships

Signature: ______Date:__

BAY CITY MARINE, INC:

Signature:_____Date:____



SCHEDULE OF EVENT SUBCONTRACTOR'S WORK ASSIGNMENTS

ITEM NO.	PARA.	SUBCONTRACTOR	
33-41-002 Part I	3.3.1	S.D. Boat Movers	
part II	3.2 thru 3.4.4	Cleaning Dynamics	
Part III	3.10 thru 3.12	Quality Sandblasting	
Part IV	3.7	Quality Sandblasting	
Part V	3.2 thru 3.3	Coastal Rigging	
Fart VI	3.3 thru 3.8	Cal-E-Wo	
Part VII	3.4 thru 3.6	Code Welding	
Part VIII	3.3 thru 3.19	Code Welding	
nort IX	3.7	Cal-E-Wo & Code Welding	
33-41-003 Part I	3.3.1	SWM's Crane Service	
Part II	3.2 thru 3.4.4	Cleaning Dynamics	
Part III	3.3 3.10 thru 3.12.2	SWM SWM	
art IV	3.9	SWM	
ŗı	3.15.1 thru 3.15.1.3	Coastal Rigging	
art V	3.2 thru 3.3.1 3.3	Coastal Rigging SWM (Crane & weights)	
art VI	3.2 thru 3.15	Cal-E-Wo	
art VII	3.6	Insulation Specialist	
art VIII	3.7 thru 3.12	National Pump & Injector	

.IARKS:

Page 1 of 2
1411 Harding Avenue • National City, CA 92050 • (714) 474-8121



SCHEDULE OF EVENT

SUBCONTRACTOR'S WORK ASSIGNMENTS

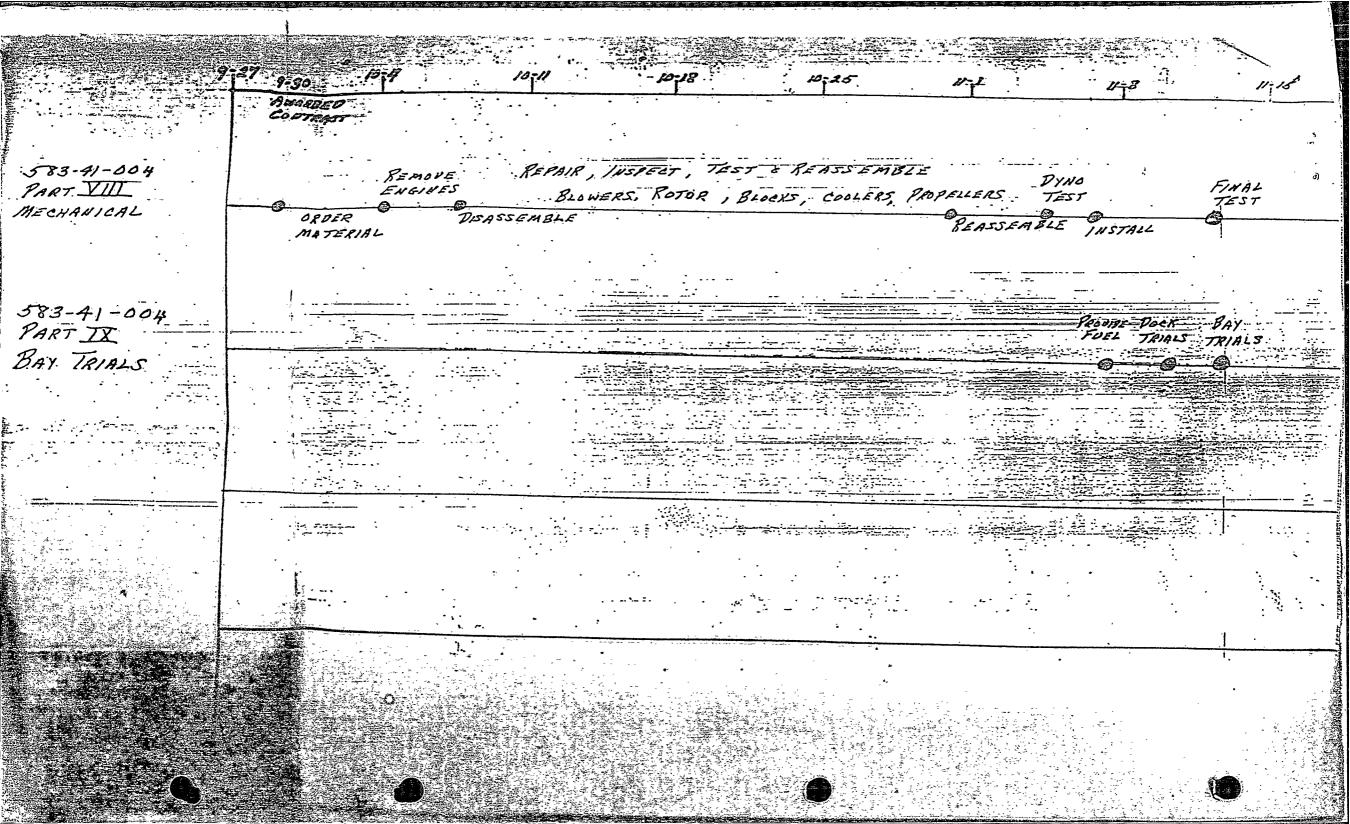
,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		
ITEM NO.	PARA.	SUBCONTRACTOR
583-41-003 Part IX	3.5 3.7 thru 3.7.2	Cleaning Dynamics N.P.&I, Cal-E-Wo, A & E
583-41-004 Part I	3.3.1	SWM's Crane Service
Part II	3.2 thru 3.4.4	Cleaning Dynamics
Part III	3.3 and 3.10 thru 3.12.2	SWM
Part IV	3.9	SWM
Part V	3.2 thru 3.3.1 3.3	Coastal Rigging SWM (Crane & weights)
Part VI	3.2 thru 3.15	Cal-E-Wo
Part VII	3.6	Insulation Specialist
Part VIII	3.7 thru 3.12	National Pump & Injector
Part IX	3.5 3.7 thru 3.7.2	Cleaning Dynamics N.P. & I, Cal-E-Wo, A & E
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REMARKS:

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	AMARGET CONTRACT		
 			
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583-41-004 PART I	FREUNINARY HOLL INSPECTION	MAINTAIN-DXY BERTHING	
DRY BERTHING			
583-41-004	REMOVE		
PART IL GAS FREE	SEMONE GAS FREE REPORT	MAINTAIN GAS FREE	
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583-41-604 PART TIT	REMOUS BLASTING	HOLL INSP.	COMPLETE
PART III. PRESERVATION	ACCESS. CUTS	· · · · · · · · · · · · · · · · · · ·	PAINTING LAWRENGE LAW
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9,27	9-30. Post Post Post Post Post Post Post Post	-10-118 : 10-25	<i>D</i> =1	11-18
583-41-004 PART IX.	BLASTING	START HOLL REPAIRS SHOP TEST RAMP WIRE	COMPLETE REPAIRS	
REPAIRS			AIR TEST	-
583-41-004 PART V LIETING SLING	CLEAU SLING	SHOP TEST	BOOT WIGHT TEST	
583-41-004 PART VI	REMOVE SHOP TO A	REPLACE STEERING IN	STALL SRELIMINARY UTCHES TEST	FINAL TEST
ELECTRICAL	MATERIAL	REPAIRS		
583-41-004 PART VII	BEMOVE ACCOM INTERFERENCE REPAIRED		TEST SYSTEM	
PIPING	MATERIAL	PIPING VALVES COOLERS	SYSTEM	

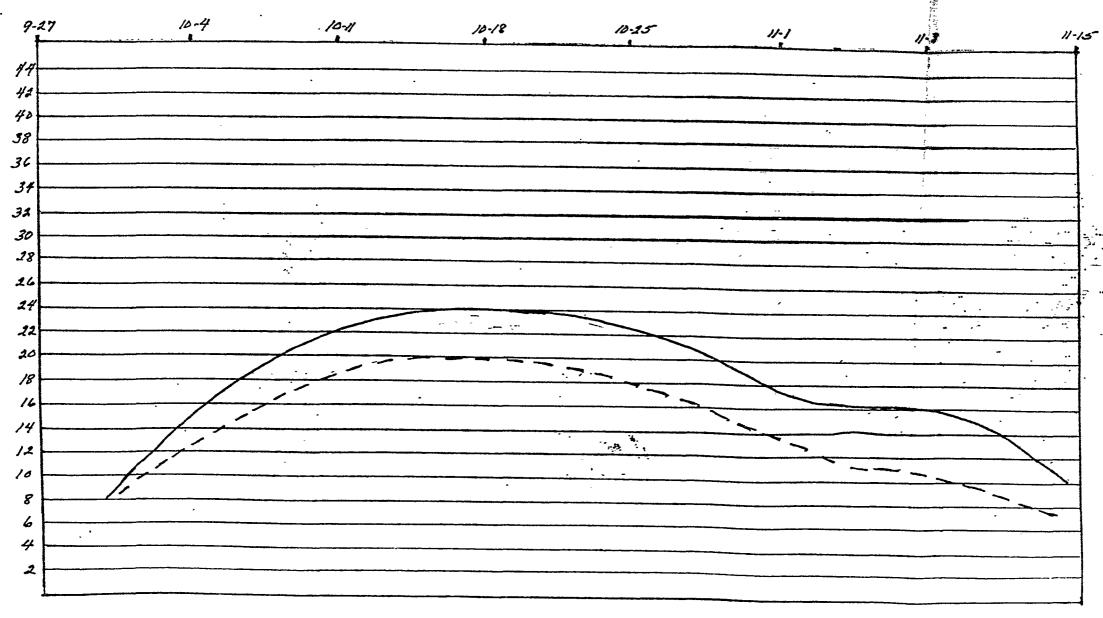


9	AMERICANT CONTRACT	16-11 -10-18	M-25	N-L	11-15
			· · · · · · · · · · · · · · · · · · ·	· · · · · · · · · · · · · · · · · · ·	Boat
583-41-002 PART Y LIFTING SLINGS	REMOVE SUNGS	7 	EST	: .	WEIGHT TEST
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583-41-002 PART VI		TEST TO REPAIRS		PRELIMIAN TEST	FINAL
ELECTRICAL	ORPER MATERIAL				SEA
583-41-002 PART VII	INTERVERENCE	CCOMPLISH SPAIRS		PREKIMINI	TEST
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583-41-002 PART_VIII	REMOVE REMOVE ENGI	OVE SUBMIT	e se transfer de la companya de la c	DYNO INSTALL TEST ENGINES	OPERATIONAL TEST
MACHANICAL	MATERIAL	BALANC.	EERS		
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	AWARBED" CONTRACT"	
583-41-002 PART IX		PROVIPE POCK SAY FUEL TRIALS TRIALS
BAY TRIALS	•	SUBMIT WAMES FOR BAY TRIALS
583-41-003 PART I	HOLL INSPECTION M	MAINTAIN DRY BERTHING
DRY BERTHING		
583-41-003 PART IL	BEMOVE GAS FREE SUBMIT FUEL GAS FREE REPORT	MAINTAIN GAS FREE
GAS FREE		
583-41-603 PART_III_ PRESERVATION	REMOVE BLASTING HULL INTERFERENCE BLASTING INSP.	
PRESERVATION	ACCESS.	:

	9-27 9-30.		-10-18	18,25			
•	AWARDED CONTRACT						
583-41-003 PART IV		BLASTAR	START HULL REPAIRS			CAPLETE	
REPAIRS			SHOP TEST RAI	· · · ·		AIR TEST	
583-41-003	· · · · · · · · · · · · · · · · · · ·	· · · · · · · · · · · · · · · · · · ·					<u>:</u> : : : :
PART IL LIETING SLING		SLING-	5.10 P 7.25 T			WEIGHT. TEST	
583-41-003 PART VI	REMOVE INTERFERENCE	CE SHIP TO	REPLACE CARTES	STEBRING INS COUTROL SNI	TALL TOBES	PRELIMINARY TEST	FINAL TEST
ELECTRICAL	OFFER	AL	PAIRS		ivali aşibili.		
583-41-003 PART VII	REMOVE INTERFEREN	CE REPAIR	PHISH			TEST SYSTEM	
PIPING	MATERIA	44	MODIFY OV PIPING V.	ERHAUL KEEL ALVES COOLERS	FLUSH SYSTEM	.	
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MANPOWER



9-27		9-11 -10-18	M-25		
583-41-002 PART I PRY BERTHING	AWARDED CONTRAST HULL /NSPECTION	MAINTAIN D.	RY BERTHING		Deliver Crafts
583-41-002 PARTII GAS FREE 583-41-002 PARTIII	GAS SUBMIT FREE REPORT REMOVE INTERFERENCE BLAST		GAS FREE	COMPLETE	
PRESERVATION 583-41-002 PART IV REPAIRS	RECORD MARKINGS REMOVE FUEL TANKS	HULL REPAIRS		COMPLETE	

LETTER OF	TRANSMITTAL No. LOT 2(R1)
FROM: BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050	Contract: 116-81 Date: 10-9-81 LCM-6 Vessel: USS DURHAM Hull: LCM-8
TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119 San Diego, California 92136	Item:Mod Spec. S/D688-81 Reference:
Attn: Code #1509_1D	ь6 ь7с
Required Report(s) XX Schedule of Events Excess Material Supships S/ > 4500/2 Drawing(s) Test Memo J.O. Exception(s) Completed	Enclosure(s): RESUBMITTED SCHEDULE OF EVENTS 1) PRODUCTION SCHEDULE 2) MANPOWER LOADING CURVE 3) SUBCONTRACTORS LIST
Comments:	
Signa Date: 10-9-81	Supships Signature:Date:

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BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050	Contract: 116-61 Vessel: LCN 8 & LC4-6	Date:1.3-2-8)Hull: <u>BDPMAN</u>
TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119 San Diego, California 92136	\$ (0.5) #e e	Mod
Attn: Code #	Reference:	
✓ Required Report(s)	Enclosure(s):	
☐ Schedule of Events	1) PERSONNEL AUTHORIZ 10MS AND TEST.	ed to perform inspe
☐ Excess Material		
☐ Supships S/) 4500/2		
☐ Drawing(s)		
☐ Test Memo ,		1
☐ J.O. Exception(s) Completed		
Comments:	! !	
BAY CITY MARINE, INC.	Supships	
and the second s	Signature:	

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PERSONNEL AUTHORIZED TO PERFORM INSPECTIONS AND TESTS

The following personnel are author Contract: 1/6-81 Spec. No. S NAME		el DURHAM LCH-S	b6 b70
NAME	TEL. (WORK)	Tri /iidiml	•
		TEL. (HOME)	
			Mallers
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Authorized by 141 / Harding Avenue	Date 10/2 National City, CA 920	050 • (714) 474-8121	

LETTER OF	FTRANSMITTAL No. LOT 6
TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119 San Diego, California 92136	Contract: 116-81 Date: 10-12-81 Vessel: LCM-8 Hull: 74CM6765 Item: 583-41-003 Mod. Spec. S/D 688-81
Attn: Code #	Reference:
Required Report(s) Schedule of Events Excess Material Supships S/ > 4500/2 Drawing(s) Test Memo J.O. Exception(s) Completed	Enclosure(s): 1) REQUEST HULL INSPECTION PER PARA 3.16 OF ITEM 583-41-003: PT III OF IX.
	0cT
REQUEST FORMAL HULL INSPECTION 0900, RECEIVED & NOTED INSPECTION ARRANGED FOR I	DATE 10/1548/ 55 DISTRIBUTION 3
Signature Date: 10-12-81	Supships Signature ate: 10/14/8/

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LETTER C	OF TRANSMITTAL	No. 1.07 6
FROM: BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050	Contract: 116.91 Vessel: 174.9	Date: <u>10-12-01</u> Hull: 740:90765
TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119 San Diego, California 92136	Spec. S/D588_81	Mod
Attn: Code #	Reference:	ь6 ь7с
⚠ Required Report(s)☐ Schedule of Events☐ Excess Material	Enclosure(s): 1) REQUEST HULL INSPECT ITEM 583-41-003: PT	ion per para 3.16 (
☐ Supships S/) 4500/2 ☐ Drawing(s) ☐ Test Memo		CONTRACT
☐ J.O. Exception(s) Completed		ACTS
Comments: REQUEST FORMAL NULL INSPECTION 0900	, 10-14-81	
	-	
Signatur Date:	Supships Signature:	Date:

LETTER OF	TRANSMITTAL No. 1016
FROM: BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050 (714) 474-8121 TO: Supervisor of Shipbuilding Conversion and Repair, USN	Contract: 116-8 Date: 16- Vessel: 16 M - 8 Hull: 14 Mod. Spec. S/D 6 8-8-8
U.S. Naval Station, Box 119 San Diego, California 92136 Attn: Code # 1509. D	Reference: b6 b7c
Required Report(s) Schedule of Events Excess Material Supships S/D 4500/2 Drawing(s) Test Memo J.O. Exception(s) Completed	Enclosure(s): (1) REQUEST HULL INSPECTION PER PARA COMPS 3.16 OF THEM 583-41-003; PT III OF IX.
REQUEST FORMAL IJULL J	ENSPECTION 0900 10-14-81
BAY CITY MARINE, INC. Signature: Date:	Supships Signature:Date:

LETTER OF	TRANSMITTAL No. 104
EROM: BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050	Contract: 190 04 Date: 100 100 100 100 100 100 100 100 100 10
TO: Supervisor of Shipbuilding: Conversion and Repair, USN U.S. Naval Station, Box 119	Item: Mod. Mod.
San Diego, California 92136 Attn: Code #	Reference:
Required Report(s)	Enclosure(s):
☐ Schedule of Events ☐ Excess Material ☐ Supships S/ 2 4500/2	1) PEQUEST HULL INSPECTION PER PAPA 3.16 OF ITEM 500-41-003: PT 111 OF IX.
☐ Drawing(s)	
☐ J.O. Exception(s) Completed	
Comments:	
在在一个人,我们就是一个人的人,我们就是一个人的人的人,我们就是一个人的人的人。 《《《《《《》》》(《《》》)。	
BAY CITY MARINE, INC.	
Signature Date:	Supships Signature:Date:

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Commen	ts:			
Scher	ired Report(s) dule of Events s Material hips S/) 4500/2 ing(s) Memo Exception(s) Completed ESS CONTROL PROCEDI	·	Enclosure(s): 1. PROCESS CONTROL FROCED FLUSHING OF HYDRAULIC SYSTEM	
FO: Sup Cor U.S San	1411 Harding Aver National City, CA 92 ervisor of Shipbuilding eversion and Repair, USN Naval Station, Box 119 Diego, California 92136	ue 2050	Contract: 116-61 Vessel: 108-8 a. 563-41-003 PT VIII Item: 5. 533-41-004 PT VIII Spec. S/D 695-91 Reference:	_Date: <u>10-12-31</u>



To: Supervisor of Shipbuilding, Conversion and Repair, USN Naval Station, Box 119 San Diego, CA 92136

3.1.1 Via: Bay City Marine 1411 Harding National City, CA 92050

3.1.2 Date Developed: 10-12-81 Item #583-41-003 & 583-41-004 PT VIII OF IX

3.1.2 Process Number: 150-81 CDC.W.O.# 2198-7 & 2198-11

3.1.2 Process Control Procedure for Flushing the Steering Hydraulic System of the LCM-8 #74CM6765 & #74CM6783

3.1.2 References Utilized: PSNSY Process Instruction #0516-905-0411, Ch. 2, Appendix 4, Process Control Procedure

3.1.3 Equipment Utilized:

Shipboard

- 1. I air operated, rotary pump, MFG. by Ryan Co. for particle flush
- 2. 1-1½ stainless steel, double teflon diaphram, water actuated air operated freon pump MFG. by Gordon Rupp Co.

- 3. 1 stainless steel, 2 micron filter4. 1 stainless steel (20 gallon capacity) portable sump tank
- sufficient freon and oil resistant hoses to accomodate flush and circulate hook ups.

B. Yardside

- Sufficient amount of PCA freon MIL-C-81302 or equivalent for systems piping flush.
- 2. I stainless steel, teflon double diaphram, water actuated, air operated, transfer pump MFG. by Gordon Rupp Co.
- Sufficient quantities of teflon hose or equivalent used to transfer cleaning solvent and hydraulic oil into ship piping.
- Sufficient quantities of hydraulic oil for flushing and filling system.

3.1.3 PROCESS DESCRIPTION:

In order to flush the hydraulic system all the jumpers will have to be removed. These jumpers are to be removed by the Prime Contractor to provide fittings and flanges to accommodate flushing jumpers. Freon and oil resistant flush hoses will be attached at the flanged ends in order to give a complete flow of both freon and hydraulic oil through out the entire steering pipe hydraulic system. All flex hoses will be returned and shop cleaned by Cleaning Dynamics Corporation.

SCOPE:

The flushing shall be conducted in two (2) steps:

(1) For piping and sump on the ship.

(2) For all hydraulic hose removed for shop clean.

STEP #1

The first part of the flush will incorporate the shipboard piping. The 1½" piping from the Engine Room into the Lazarette to the Steering Room, and return line piping back to the forward sump tank. Chemical resistant jumpers shall be installed at pipe ends connecting the flushing equipment, to the piping and jumping the piping where components and hoses have been removed, to form a continuous flushing path from flushing pump and returning to same. The flushing solvent may be displaced and discarded if the return solvent is heavily contaminated until a clean return is obtained and then connected up to the recirculation flushing equipment. Start the flush until the return solvent is clean. Take a sample and have analyzed by a certified Marine Chemist, to meet Class 8 of PSNSY Process Instructions #0516-905-0411 Chapter I, Appendix 4. When piping is clean, empty system of freon solvent, blow piping dry with certified nitrogen and test for hologenated solvent with a G.E. H-10 Halide Tester. When piping is dry, pump clean syste oil and coat the piping. Empty system, remove flushing equipment cover ends with viscuine and tape to seal ends in preparation of system being put back together and made ready for operational.

STEP #2

Hydraulic Flex hoses removed from the piping system shall be taken to Cleaning Dynamics Corporation's yard for shop clean to a grade "A" visual cleanliness criteria as called out in PSNSY Process Control Procedure 0516-905-411 Chapter I for shop cleaning paragraph 2.1 page 3. Upon delivery to Cleaning Dynamics Corporation's yard, Flex hoses shall be steam cleaned to remove oils and contaminates. Hoses shall be blown dry with certified nitrogen, inspected and ends sealed with viscuine and tape for delivery to the ship awaiting installation back into the system.

**NOTE: CAUTION SHOULD BE USED IN TRANSPORTING THE HOSES TO INSURE THE ENDS DO NOT BECOME UNWRAPPED OR BROKEN. ANY HOSE ENDS FOUND OPEN, UPON ARRIVAL AT SHIP, WILL BE RETURNED FOR RECLEAN AT CLEANING DYNAMICS CORPORATION'S YARD.

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The sump shall be opened and hand wiped with lint free wipes, and inspected. Prime Contractor to reinstall hoses, filters, components to make system operational. System shall then be be filled with clean, new hydraulic oil conforming to Navy Sym. 2135 and operated. After one hour a sample shall be taken to a laboratory for analysis for Class 9 PSNSY Process Instruction #0516-905-0411 Chapter 2, Appendix

**NOTE: DUE TO FLASH RUSTING OF SUMP WHEN CLEANING WITH FREON, LINT FREE WIPES SHALL BE TULIZED AND VISUALLY INSPECTED. FLOW RATES OF PUMPS ARE FROM 10-60 GALLONS PER MINUTE.

12" PIPING IS RATED AT 10 G.P.M.

3.1.4 QUALIFICATION REQUIREMENTS:

		Crew utilized			
are	superior	in knowledge a	nd in their	field of wo	ork. They have
all	had a min	nimum of one ye	ar of train	ing and expe	erience but
comb	ined have	an average of	five years	experience	in the field
of c	hemical w	<u>ork</u> including.	High Criter	ja Cleaning.	
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The starrage	 	

The above are required to have direct knowledge of jobs assigned, including the following:

Complete understanding of the operation of the system for systems being worked.

Complete understanding of the scope of the job.

Quality Assurance Requirements

Ability to foresee and resolve potential problem areas.

Abitly to utilize knowledge and experience to complete the job in a timely yet efficient manner.

3.1.5 . INSPECTION AND DOCUMENTATION FORMS:

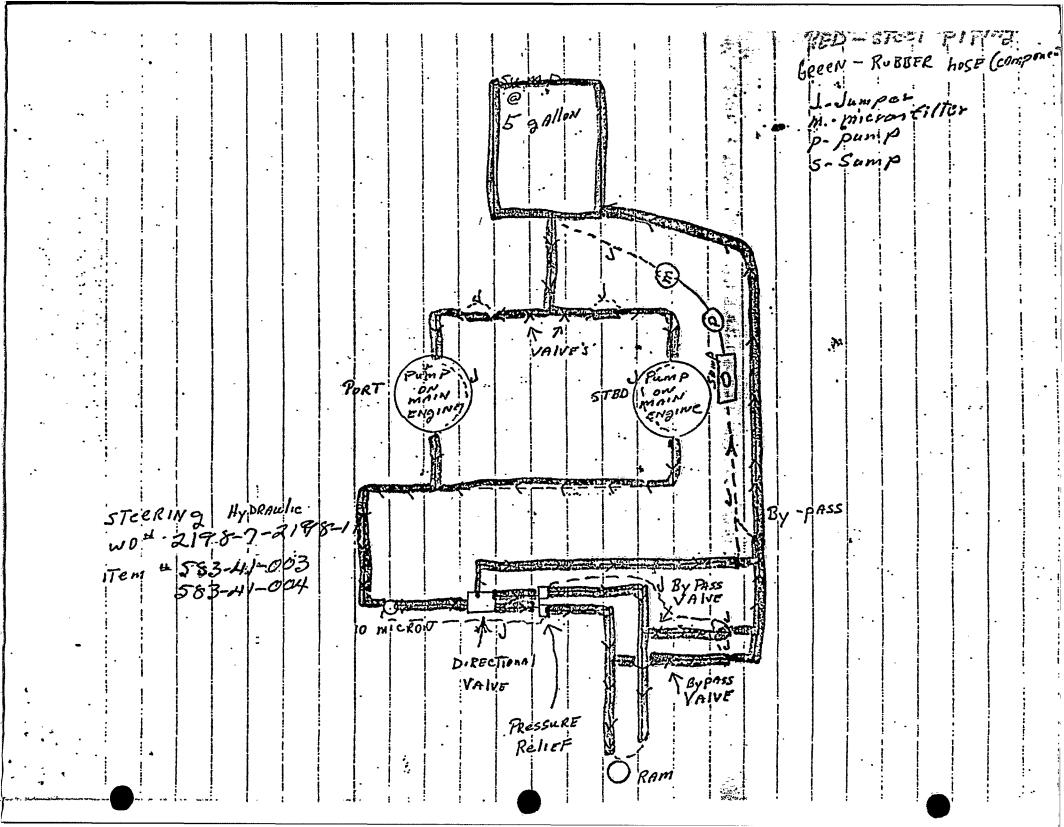
The inspection and documentation forms are those of the Prime Contractor in addition to Cleaning Dynamics Corporation's final job sign-offs for inspection of muslin bags.

3.1.6 ACCEPTANCE AND REJECTION CRITERIA:

Acceptance and rejection criteria shll be based upon PSNSY Process Instructions 0516-905-0411 Chapter 2, Appendix 4 paragraphs 4.1.2 and 5.1.2 and Process Control Procedure.

3.1.7	METHOD UTILIZED TO ENSURE PERSONNEL HAVE COMPLETE KNOWLEDGE OF JOB:	
	Prior to commencement of this cleaning procedure, all personnel involved will attend several briefings, outlining the work requirements. A copy of the procedure, specification and references shall be in possession of the Coordinator, Foreman, and Leadman during the performance of the work.	
3.1.8	THE METHOD UTILIZED TO CONTROL THE PROCEDURE:	
	The procedure will be the final job sign-offs which follows the cleaning process.	
3.1.9	Sub Contractor Approval	
	BCM's Representative :	
	Supships Representative	
•	Name Date Title b	6 7C
	Cleaning Dynamics Corporation	

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LETTER OF	TRANSMITTAL No. 181 10
BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050	Contract: 116_81 Date: 16_15_81 Vessel: 164.8 Hull: 46765
TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119	Item:
San Diego, California 92136 Attn: Code #	Reference:
Required Report(s) Schedule of Events	Enclosure(s): AS FOUND REPORT
□ Excess Material□ Supships S/) 4500/2□ Drawing(s)	
☐ Test Memo ☐ J.O. Exception(s) Completed	
Comments:	
BAY CITY MARINE, INC. Signature Date:	Supships Signature: Date:

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NATIONAL PUMP & INJECTOR SALES & SERVICE, INC.

2307 East Belt Street

San Diego, California 92113

Phone: Area Code 714, 232-0831

October 14, 1981

Bay City Marine 1411 Harding Avenue National City, Calif 92050

Subject: U.S.S. Durham LKA-114

BCM 116-81. Spec #SD688-8 Item #583-41-003,LCM 8 2 each 12V71 G.M. Diesel Engines S/N 12VA5212795

S/N 12VA52793

Gentlemen:

The following conditions were noted and recorded during the disassembly, cleaning and inspecting of subject engine.

Engine S/N 12VA5212795

Cylinder block is cracked (See NDT Report). (1) each connecting rod bent. End plate on expansion tank eroded. Fuel lines damaged. Blower coupling assembly damaged. Crankshaft is worn beyond manufacture wear limits. Cam rollers worn and scored.

Transmission & P.T.O.

Forward clutch plates worn and scored. Bearings show heat discolorate Forward clutch springs broken.

Missing Parts Report

Generator, hydraulic pump (RPA).

Engine S/N 12VA52793

Cylinder block cracked (See NDT Report). Cam rollers worn and scored Rocker arm shafts worn and scored. Rocker arms worn through hardened surface. Both valve covers damaged.

Bay City Marine

Page #2

Continue

Transmission & P.T.O.

Tyr.

Forward reverse clutch plates worn and scored. Bearings worn and scored. Forward clutch springs broken.

Missing Parts Reports '

Generator, hydraulic pump (RPA).

Recommend the following list of material be repaired and or replaced

Engine S/N 12VA5212795

1	5135756	CONNECTING ROD	
1	5123741	· END PLATE EXPANSION TAN	NΚ
1	5150344	BLOWER COUPLING	

Transmission

1	MA648	BALL BEARING
1	MA647	ROLLER BEARING
2	M2175B	BALL BEARING
2	M2104	BALL BEARING
2	MA649	BALL BEARING
1	M2475A	ROLLER BEARING
2	MA293	ROLLER BEARING
1	M2167	BALL BEARING

Engine S/N 12VA52793

VALVE COVER VALVE COVER INST KIT

Bay City Marine Page #3

Continue

Transmission

1	MA648	BALL BEARING
1	MA647	BALL, ROLLER
2	M2175B .	BALL BEARING
2	M2104	BALL BEARING
2	MA649 .	BALL BEARING
1	M2475A	· BALL BEARING
2	MA 293	BALL BEARING
1.	M2167'	BALL BEARING

place .

Very truly yours,

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		b6 b7С

RJC/ec

NATIONAL PUMP & INJECTOR SALES & SERVICE, INC.

2307 East Belt Street

San Diego, California 92113

Phone: Area Code 714, 232-0831

October 15,1981

Bay City Marine 1411 Harding Avenue National City, Ca 92050

Subject: U.S.S. Durham LKA-114

BCM 116-81 , Spec #SD688-81 Item #583-41-004

(2) each V-12-71 Diesel Engin

Gentlemen:

Subject blocks were reported	as cracked as per NDT Report. B	locks
were inspected by	as requested by SupShips San Die	go, Ca
and were reported as not revelant	indications. Both cylinder block	ks are
satisfactory for reuse.		b6 b7С
	Very truly yours,	

RJC/ec

	<u></u>					BLACK LI			Pl	none:	263-3	135			Lab. No: F-154 Invoice: Date: 10-12-81 Cust. P.O. Part No: W/O #15628-4
	X-RAY	CISI	VE.			EDDY CUI	RENT		,						Part No: W/O #15628-4
		ARTICLE,	//	/ T	ES	FING	IN	c:/		، . د	•		•		Part Name: ENGINE PARTS
4582	FED	ERAL	BLV	D. SA	N DIE	EGO,	CA. 9	 2102	٠,٠,٠	٠,	••				Quantity: (4) EACH Art # BCM-116-81
					•					•					Spec. No: SD 688-81 Item No: 583-41 200 #8
SHIP		BA	CI'	TY M	ARIN	ΙE							•		Contract No.
	REF	: Nat	ion	al P	ump		niec			3.					Location: USS DURHAM LKA-114
		23	307 ·	East	Bel	t Si	tree	t							RADIOGRAPHIC INSPECTION □
ą		.Sa	an D	iego	, Ca	llfo	orni	a 9	2113	3				•	Standard:
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628-2	 		V1	V2	V3	V4°	V5	V6	V7	V8	V9	V10	V11	V12	LIQUID PENETRANT INSPECTION
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											†				Prep. of Surface: BLCK LIGHT X Dry: X
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SUPERVISOR OF SHIPBUILDING, CONVERSION AND REPAIR, USN 11ND DIMENSIONAL INSPECTION REPORT

SUBJECT:	CYLINDER BLO	CK BORES S	S/N 12VA5212	2795 ·	(RIGHT BAN	NK)	
	BAY CITY 1				,		
SHIP:	USS DURHAN	M LKA-114 (CONTRACT NO	: BCM	116-81	SPEC NO): <u>SD-688-81</u>
		· O/OR SKETCH I	REFERENCE				
		MFG.	WEAR LIMI	rs .		-	

			-				
CONTRACTOR	OC INSP			UPSHI	PS REP.		b6 b7C
MEACHDING	INSTRIBUTANT USI	n BORE GAUG	ES C	ONTRO	I NC. DRG-	DATE	LAST BRATED 8-24-81
PHINOCHAIN .	·	2D	,	MI INO	L 110	T CHAIL	0 24 01
	NGS AS FOUND	1			CAĹ	IBRATION HA	ARKED (YES) NO
PART OR PC NO.	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSIO	,	ACCEPT	REJECT	
i'1	4.6265		т. 4.6273		ХХ		
CYLINDER	4.6275	.001	M. 4.6273 B. 4.6270		XX XX		
#2	4.6265		T. 4.6273		XX		
CYLINDER	4.6275	.001	M. 4.6274 B. 4.6269		XX XX		
//3	4.6265		T. 4.6274		XX		
CYLINDER	4.6275	.001	М. 4.6273 В. 4.6268		XX XX		
#4	4.6265		r. 4.6271		XX		
CYLINDER	4.6275	.001	M. 4.6271 B. 4.6265		XX XX		
<i>#</i> 5	4,6265		г. 4.6274		XX		
CYLINDER	4.6275	.001	M. 4.6272 B. 4.6271		XX XX	•	,
	1 (0(5		r. 4.6275		XX	•	
#6 CYLINDER	4.6265 4.6275	.001	M. 4.6274 B. 4.6270		XX XX		
			1.0270	<u>-</u>	AA.		
	1	3	1				i i

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		DIME	NSIONAL INSP	CONVERSION AND ECTION REPORT	REPAIR, USN	11HD
OUNECT:	•	BLOCK BORES	s/N 12VA5212	2795 (LEFT BANK)		
CONTRACTOR	BAY CITY	MARINE				
us Saup:	S DURHAM LKA-	-114	CONTRACT NO:	BCM 116-81	SPEC NO	SD-688-81
ANTICLE NO	583-41-00	03 . PAKA HO:	·3.7.10.49	IDR NO:	P11 NO:_	SD-688-81
		AND/OR SKETCH				
•		,				
						b6
CONTRACTOR	QC INSP	·	susu	PSHIPS REP.		b6 b7C
MEASUR LNG	INSTRUMENT	USED BORE GAT	JGES CO	NTROL NG. DBG-1	DATE CALIE	LAST BATED 8/24/81
READIN	GS AS FOUND			CAL	IBRATION HA	RKED (YES) NO
PART OR PC NO.	REFERENCE DIMENSION		MEASURED DIMENSION	- ACCEPT	REJECT	
#1 CYLINDER	4.6265 4.6275	.001	T. 4.6274 M. 4.6270 B. 4.6267	XX XX XX		
82 CYLINDER	4.6265 4.6275	.001	T. 4.6273 M. 4.6274 B. 4.6271	XX XX XX		
#3 CYLINDER	4.6265 4.6275	.001	T. 4.6273 M. 4.6272 B. 4.6266	XX XX XX	•••	

T. 4.6273

M. 4.6268

B. 4.6266

T. 4.6271

M. 4.6270

B. 4.6266

T. 4.6275

M. 4.6272

B. 4.6265

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Committee of the second second

SUPERVISOR OF SHIPBUILDING, CONVERSION AND REPAIR, USN 11ND DIMENSIONAL INSPECTION REPORT

SUBJECT:	CRANKSHAFT 1	IAIN BEARING	OURNALS	s/N	1 12VA5212795	5			
CONTRACTOR	BAY CITY MÀI	RINE			•				
SHIP: USS	DURHAM LKA-114	<u>4</u> c	ONTRACT	NO:	BCM 116-81	SI	PEC NO:	SD 688-81	-
ARTICLE NO	: 583-41-003				0.49 IDR 1		PM	ΝΟ:	
NAVSHIP AN	id/or flan and	• •							
				-	•			·•	
·									
CONTRACTOR	QC INSP.			SUPSHI	PS REP.				b6 b70
	INSTRUMENT US	EDMICROMETER	4-5"	•		DATE CALII	LAST BRATED	9/10/81	
	•		,	•					
PART OR	ADINGS AS FOUN REFERENCE	REFERENCE	MEASU	RED	CALIBRATIO	N MARKED	YES	NO	•
NO.	DIMENSION	TOLERANCE	DIMEN		ACCEPT'	REJECT	ļ		
#1	4.499 4.500	.001	4.4	98		xx			
#2	4.499 · 4.500	.001	4.4	97		ХХ			Table (Controlling)
#3	4.499 4.500	.001	4.4	985		хх			
04	4.499 4.500	.001	4.49	75		хх			
# 5	4.499 4.500	.001	4.4	985		XX			*******
# 6	4.499 4.500	.001	4.4	975		XX			
	4.499 4.500	.001	4.4	99 .	xx				

SUBJECT:	CONNECTING	ROD, JOURNALS	CRÁNKSHAFT	S/N 12VA5	212795	
CONTRACTOR	: BAT CITY MAR	INE				
SHIP: U	SS DURHAM LKA	-114 CONTRA	ACT NO: BCM	116-81	SPEC	: NO: SD-688-81
		•				10:
NAVSHIP AN	D/OR PLAN AND,	OR SKETCH RE	FERENCE:			
•		MFG. WEAR	LIMITS .	•	· 14	
	•					t.
COMPA CEOR	oc tych					b6 ——— b7C
CONTRACTOR	de mar.		Sursh	ilps ker.		DATE LAST 9/10/81 CALIBRATED
MEASURING	INSTRUMENT US	ED 2-3" mic	CONTR	OL NO21		CALIBRATED
ADINGS AS I	FOUND			CALIBRATION	MARKED (Y	res) no
PART OR	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSION	ACCEPT	REJECT	
#1		100000000	021121102011			
	2.999 3.000	.001	2.999	- xx		
#2	0.000					
11 Z	2.999 3.000	001	2.999	xx		
J. 3						
#3	2.999 3.000	.001	2.999	· XX		
	2.999					
#4	3.000	.001	2.999	XX		
	2.999				•	
<i>\$</i> 5	3.000	.001	2.999	. xx	. •	
						•
#6	2.999	.001				
	3.000	.001	2.999	XX		
				.: "		

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SUBJECT:	CAMSHAFT	JORNALS	(KIGH)	() S/N	12VA5212795		
CONTRACTOR	BAT CITY	MARINE		,		·	
SHIP: USS	S DURHAM LKA-1	114 · CON	TRACT NO:	BCM	116-81	SPEC	NO: SD-688-81
		_					:
NAVSHIP AN	D/OR PLAN AN	D/OR SKETCH	REFERENCE		•		t a
			IFG. WEAR				
			`				
CONTRACTOR	QC INSP		,	SUPSH	IPS REP.		b6 b7C
MEASURING	QC INSP	ED 1-2" mic		CONTR	ol no. M1-22	DA' CA	TE LAST 9/10/81
			•				
	AS FOUND				CALIBRATI	ON MARKED	(YES) NO
l .	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASU DIMEN		ACCEPT	REJECT	
FRONT END	1.4970 1.4975	.0005		•			
au oodiini	1.4775	.0003	1.4960			XX	
INTERMEDIA	1						
#1	1.4985	.0005	1.4975			XX	
#2	1.4980			n.			
	1.4985	.0005	1.4980	,	XX		
#3	1.4980				,	_	
	1.4985	0005	1.4980		XX	•	
#4	1.4980					. •	
	1.4985	.0005	1.4975		,	XX	
# 5	1.4980			,			
į.	1.4985	.0005	1.4975	•.		XX	,
REAR END	1.4970						
CAM JOURNA	L 1.4975	.0005	1.4965			XX	

 $\beta \delta V_{i} \in \mathcal{S}$

SUBJECT:	CAMSHAFT	JORNALS	S/N 12V	A52127	95 (LEFT)		
CONTRACTOR:	BAY CITY MA	RINE					
SHIP:	DURHAM LKA-11	.4 · CONTI	RACT NO:	BCM 116-81 SPEC NO: SD-688-8			
ARTICLE NO:	583-41-003	PARA NO:	3.7.10.49	1	DR NO:	PM NO	
NAVSHIP ANI	O/OR PLAN ANI	o/or sketch ri	EFERENCE	٠.	•		4
		MFG WEA					
<u> </u>							
	•						b6 -
					·		b7C
CONTRACTOR	oc insp.			SUPSHI	IPS REP.		
001121010101		1-2" mic			M1-22	DA'	TE LAST 9/10/81 LIBRATED
MEASURING 1	INSTRUMENT US	ED		CONTRO	or no.	CA	LIBRATED
READINGS A	AS FOUND		•		CALIBRATI	ON MARKED	YES NO
PART OR	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASU! DIMENS		ACCEPT	REJECT	
FRONT END		TOBERANCE	DETIBLE	1	10001	REGEOT	,
CAM JOURNAL		.0005	1.497		XX		
1 1	re 1.4980		1.498		ХХ		
#1	1.4985	.0005					
#2	1.4980						
11: 4	1.4985	.0005	1.498	'	XX		
#3	1.4980		1 400		vv		
	1.4985	.0005	1.498		XX		
	, , , , , , , , , , , , , , , , , , , ,					, •	•
#4	1.4980 1.4985	0005	1.498		XX		
#5	1.4980		7 407			7777	
1 3,	1.4985	.0005	1.497	•	*********	XX	
			-				
REAR END	1.4970 1.4975	.0005	1.497	:	XX	: 77.	
Car. Coolain	21.1773						
				_,			

UNIECT:	GEAR YRAIN	BACK LASIIES	Ś/N 12VA521	.2795		
TRACTOR:	BAY CITŸ	MARINE	, •	•	•	
UEP:	SS DURHAM LKA-	114 · · · · co	NTRACT NO. BCM	116 - 81		SPEC NO: SD 688-81
EXICLE NO:	583-41-003	PARA. N	3.7.10.49	IDR NO:		SPEC NO: SD 688-81 PM NO:
	O/OR PLAN AND		•	*Lucia Ma		,
, ,		•	AR LIMITS		•	*
, man 1981			, , ,			
					·	4
						b6
CHTRACTOR	QC INSP.		SUPSHI	PS REP.	D	b6 b7C NATE LAST 9/10/81
TASURING 1	INSTRUMENT US	ED DIAL IND.	CONTRO	L NO. D1-3		CALIBRATED 9710/01
READINGS A	S FOUND		CALTRE	ATION MARK	ED (YES)	но
	REFERENCE	REFERENCE	MEASURED			
CAM TO	DIMENSION	TOLERANCE	DIMENSION	ACCEPT	REJECT	
Q EAR	.003 .008	.005	005،	xx		
RI CAM TO						
RU CAM TO EDLER GEAR	.003 .008	.005	.004	XX		
IDLER TO						
CRANK- SHAFT	.003		.004	xx		•
GEAR	.008	.005			••	
Blower Drive	.003		.006	· xx	•	
GEAR	.008	.005			•	
		,	•	* 4		••
						•
				••		
/3vvv						
#3						
hyden and a second and a second						

THECT:		CRANKSHAFT,				S/N 12VA521	2795	
RACTOR	BAY CITY MAI	RINE			1.		•	•
		14				SPEC N	o: SD-688-83	_
		³ PARA. NO.			•			
							·•	AND STREET
ASHTA WI	D/OR PLAN AND	O/OR SKETCH RE	=			•		
	•	rirg. (WEÄK LIMI					
3.3		• • • • • • • • • • • • • • • • • • •						
77		,		·	· · · · · · · · · · · · · · · · · · ·			
TRACTOR	QC INSP			SUPSH	IPS REP,	٠		, b6 b7C
*ASURING	INSTRUMENT US	ED DIAL IND					LAST BRATED 9/10	/81
	•				_			
	ADINGS AS FOUN				CALIBR	ATION HARK	ED (YES)	NO
ON NO.	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASU) DIMEN		ACCEPT	REJECT		
PT PT	.004 .011	.007	•	.017	·	xx		
AM (R)	.004 .012	.008	` .	.010	·xx ،			
CAM (L)	.004	.008		.008	XX	_		
**************************************	s			£	,			
N, Yaqida da kalinda qayada ahada da a								
PT (4 months)								·
	•	•						•

•	akse s	Settle, e	•	•		
SUBJECT:	BLOWER CL	EARANCE S/	'N 12VA-5212	795 (REAR)		
CONTRACTOR:	BAT CITY	MARINE	· · · · · · · · · · · · · · · · · · ·	•		
SHIP USS DUR	HAM (LKA-114)	CONTR	ACT NO: BCM	-116-81	SPEC	C NO: SD-688-81
				49 IDR NO:		
MAVSHIP ANI)/OR PLAN AND/	or sketch re	Perence:	·	Management of the second	
		•	. WEAR LIMIT			
·						
						ь6 ь7с
CONTRACTOR	QC INSP		SIP	SHIPS REP.	17 (
		_				DATE LAST CALIBRATED 9/10/8
				THOU WO.		
	AS FOUND .		1 MEACHINED	CALIBRATION	HARKED (res) no
PART OR PC NO.	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSION	ACCEPT	REJECT	
ROTOR TRAILING	MIN. 002	.004	.006	XX		
EDGE	MAX. 006					
ROTOR LEADING	MIN. 016	.006	.008		XX	
EDGE	MAX. 022			; , ,	,	
ROTOR TO FRONT	MIN. 007					
END PLATE	,	.002	.008	XX	••	
ROTOR TO	WIN 007					
REAR END PLATE	MIN. 007 MAX. 009	.002	.015		XX	
ROTOR TO						
HOUSING INLET SID	MIN. 017 E MAX. 019	.002	.012		XX	•
ROTOR TO	MIN. 005					-
HOUSING OUTLET	MAX. 007	.002	.006	XX		
TIMING						
GEAR BACKLASH	MIN. 0005 MAX. 004	. 0035	.0015	XX		

,			,,					
BJECT:	BLOWERWCLI	earance *S/n	12VA5212	795	(FRONT)			
CONTRACTOR:	· BAY CITY	MARINE	- projection of the second					
CHIP: USS	DURHAM LKA 11	4 CONTRA	CT NO:_	всм -	- 116 81	SPEC	NO: SD-688-8	1.
ARTICLE NO:	583-41-003	PARA N	io; 3.7.1	0.49	IDR NO:	PH, 1	10:	
MAVSHIP AND)/OR PLAN AND/	OR SKETCH REF	PERENCE:			"		
		,		· · · · · · · · · · · · · · · · · · ·	, , , , , , , , , , , , , , , , , , ,		···	
				·	• .	`		
CONTRACTOR	OC THER			CHRCHT	PS REP.		b6 b7C	10-10-10-10-10-10-10-10-10-10-10-10-10-1
•	INSTRUMENT USE	ED DIAL İŅD		CONTRO	L No D1	3	DATE LAST CALIBRATED	9/10/81
	SS AS-FOUND	FEELER GAUG	GE.		ALIBRATION			
PART OR PC NO.	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASUR DIMENS	ED	ACCEPT	REJECT		
OTOR TRAILING EDGE	MIN. 002 MAX. 006	.004	.006		xx			
ROTOR LEADING EDGE	MIN. 016 MAX. 022	.006	.010		a u a comunica a constitución de la constitución que esta esta esta esta esta esta esta est	ХХ		and the decided the decided the starped to
ROTOR TO FRONT END PLATE	MIN. 007 MAX. 009	.002	.008		XX	* 4		*
ROTOR TO REAR END PLATE	MIN. 007 MAX. 009	.002	.015			хх		Darketina M <u>atapananga anggar</u> a
ROTOR TO HOUSING INLET SID	MIN. 017 E MAX. 019	.002	.014			хх		•
ROTOR TO HOUSING OUTLET	MIN. 005 MAX. 007	.002	.007		xx			
TIMING GEAR BACKLASH	MIN. 0005 MAX. 004	.0035	.0025	5	xx			

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UDJECT:	CYLINDER BLO	CK. BORES (RIGHT BANK) SYN	12VA52793	·	
-CNTRACTOR:	BAY CITY N	IARINE		•	**	
MEP: USS	QURHAM LKA-114	(CONTRACT NO: BCM	116-81	SPEC NO:	SD-688-81
LITICLE NO:	583-41-003	PARA NO:	3.7.10.49 ID	R NO:	Pri No:	
TOARHIB WHE		O/OR SKETCH	REPERENCE		·-	•
GONTRACTOR	QC INS		sursu	IPS REP		b6 b7C
	INSTRUMENT US	ED RORE GAUG	CONTR	ol NG. <u>DBG-J</u>	DATE L CALIBR IBRATION HAR	ATED_ 8/24/81
PC NO.	REFERENCE DIMENSION	REFERENCE TOLERANCE	1	ACCEPT	REJECT	ALD SEV NO
61 CYLINDER	4.6265 4.6275	.001	T.4.6269 M. 4.6267 B. 4.6264	XX . XX XX		
02 Cylinder	4.6265 4.6275	.001	T. 4.6270 M. 4.6268 B. 4.6266	XX XX XX XX		
Ø3 CYLINDER	4.6265 4.6275	.001	T. 4.6270 M. 4.6271 B. 4.6267	XX XX XX	٠.	
64 CYLINDER	4.6265 4.6275	.001	T. 4.6270 M. 4.6269 B. 4.6266	XX XX XX		
05 CYLINDER	4.6265 4.6275	.001	Г. 4.6269 М. 4.6269 З. 4.6266	. XX XX XX	.•	
86 CYLINDER	4.6265 4.6275	.001	T. 4.6274 M. 4.6272 B. 4.6269	XX XX XX XX		
				,		

EUNECT:	CYLINDER BLO	CK. BORES	(LEFT BANK)	S/N 12VA52793		
CONTRACTOR:	BAY CITY MA	RINE		•		
CLUP: USS	DURHAM LKA-114		ONTRACT NO: 1	BCM 116-81	SPEC NO:	SD 688-81
				IDR NO:		
	OR PLAN ANI	•	EFERENCE			
*				•		
GONTRACTOR	QC INSP		sui	PSHIPS REP.	b6 b7C DATE	AST
DEASURING I	INSTRUMENT US	ED BORF GAUGE	co	TEOL NG. DBG-1	CALIBI	ATED 8/24/81
	• DINGS AS FOUND				LIBRATION HAI	
PART OR C NO.	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSION	ACCEPT	REJECT	
61 CYLINDER		.001	T.4.6271 M. 4.6268 B. 4.6267	XX XX		
#2 CYLINDER	4.6265 4.6275	.001	T. 4.6274 M. 4.6271 B. 4.6269	XX XX XX		
03 CYLINDER	4.6265 4.6275	.001	T. 4.6272 M. 4.6268 B. 4.6265	XX XX XX	٠.	
64 CYLINDER	4.6265 4.6275	.001	T. 4.6269 M. 4.6269 B. 4.6265	XX XX XX		
05 CYLINDER	4.6265 4.6275	.001	T. 4.6270 M. 4.6269 B. 4.6269	XX XX XX	. •	•
66 CYLINDER	4.6265 4.6275	.001	T. 4.6272 M. 4.6267 B. 4.6265	XX XX XX		

SUBJECT:	CRANKSHAFT M	AIN BEARING J	OURNALS S/N	12VA 52793	· · · · · · · · · · · · · · · · · · ·		
CONTRACTOR	BAY CITY	MARINE		·			
SHIP: US	S DURHAM LKA-	114) C	ONTRACT NO:	3CM 116-81	SP	EC NO: SD688-8	1
ARTICLE NO	583-41-00	3. P.	ARA. NO: 3.7.	10.49 IDR 1	10:	PM NO:	
NAVSHIP AN	D/OR PLAN AND	or sketch re	FÉRENCE				
Au	MFG WEAR LIM	ITS		•	**	•	
, , , , , , , , , , , , , , , , , , ,						the of suggest the form of the sign of the	
	*****************		· · · · · · · · · · · · · · · · · · ·	······································			b6
CONTRACTOR	QC INS		с с с с с с с с с с с с с с с с с с с	PS REP.			ь7с
MEASURING	INSTRUMENT US	ED 4-5" MI	C CONTRO	L NO. M 1-5	DATE CALIB	RATED 9/10/81	
	READINGS AS			CALIBRATIO	MARKED (YES NO	
PART OR NO.	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSION	ACCEPT	REJECT		
#1	3.499 3.500	.001	4.500	xx	•		
#2	3.499 3.500	.001	4.500	XX			
#3	3.499 3.500	.001	4.500	XX			
#4	· 3.499 3.500	.001	4.4990	XX			
# 5	3.499 3.500	.001	4.4990	· xx	-		•
#6	3.499 3.500	.001	4.500	XX	•	·	
#7	3.499 3.500	.001	4.4990	XX .			

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SUBJECT:	CRANKSHAFT	CONNECTING RO	D JOURNALS	S/N 12VA5279	3	
CONTRACTOR	BAY C	TY MARINE		·		
SHIP: USS	DURHAM LKA-114	CONTR	ACT NO: BCM	116-81	SPEC	: NO: SD-688-81
ARTICLE NO	583-41-003	. PARA	.PARA NO; 3/7/10/49 IDR NO:			ю:
	D/OR PLAN AND, MFR WEAR LIMITS		FERENCE:			
CONTRACTOR	QC INS		SUPSH	IPS REP		b6 b7C
READII	INSTRUMENT ÚSI NGS AS FOUND	2-3 MIC		CALIBRATION	× /	CHLIBRATED 175 17
PART OR PC NO.	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSION	ACCEPT	REJECT	
#1	2.999 3.000	.001	2.999	xx		
#2	2.999 3.000	.001	2.999	XX		
#3	2.999 3.000	.001	2.999	XX	• •	
#4	2.999 3.000 ···	.001	3.000	ХХ		
#5	2.999 3.000	. 001	2.999	XX		
#6	2.999 3.000	.001	2.999	xx xx		
	•					

N:

SUBJECT:	CAMSHAFT BEAR	RING JORNALS	(RIGHT)	S/N	12VA52793		
CONTRACTOR:	BAY CITY	MARINE					
SHIP: USS	DURHAM LKA-1	14 CONTE	RACT NO: E	BCM 1	16-81	SPEC 1	NO: <u>sd-688-81</u>
ARTICLE NO:	583-41-003	PARA NO:	3.7.10.49	1	DR NO:	PM NO	
NAVSHIP ANI	O/OR PLAN ANI	o/or sketch re	EFERENCE _				
	MFG WEAR LIM	ITS					
		•					
***************************************							b6
CONTRACTOR	QC INSP		s	UPSHI	IPS REP	DΔ	b7C TE LAST
MEASURING	INSTRUMENT US	ED <u>1-2" MI</u>	<u> </u>	ONTRO	OL NO. <u>M 1-</u>	22 CA	LIBRATED 9/10/81
RE	EADINGS AS FOL	IND ·	•		CALIBRATI	ON MARKED	YES NO
	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURE DIMENSI		ACCEPT	REJECT	
FRONT END CAM JOURNAL		.0005	1.4970	•	xx		
INTERMEDIA'	re 1.4980 1.4985	.0005	1.4980		XX		
#2	1.4980 1.4985	.0005	1.4980		XX		
#3	1.4980 1.4985	.0005	1.4980		ХХ		
#4	1.4980 1.4985	.0005	1.4980	•	xx	. •	
# 5	1.4980 1.4985	.0005	1.4980		XX	. ,	·
REAR END CAM JOURNA	1.4970 L 1.4975	.0005	1.4970		XX .		

SUBJECT:	CAMSHAFT BEAR	RING JORNALS	(LEFT)	S/N 12	VA52793	·		
CONTRACTOR:	· SAY CITY	MARINE			·	·	· · · · · · · · · · · · · · · · · · ·	
SHIP: US	ל טווהחצה (FKY	-114) CONTE	ract no:	3CH 116	5-81	SPEC N	10: SD-68	8-81
ARTICLE NO:	583-41-003	PARA NO:	3:7.10.49	I	DR NO:	PM NO:		
NAVSHIP ANI	O/OR PLAN ANI	D/OR SKETCH RE	EFERENCE	•				
	MFG WEAR LIMI	TS	•					
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# 5	1.4980 1.4985	.0005	1.4980		XX			
REAR END CAM JOURNA	1.4970 1.4975	.0005	1.4970		XX			-

DECT:	END THRUST,	CRANKSHAFT.	CAMSHAFT, BAL	NCESHAFT S	N 12VA52793	3	
ACTOR	BAY CIT,	Y MARINE	· · · · · · · · · · · · · · · · · · ·				
D8 . U	SS DURHAM LKA-	114 C	ONTRACT NO: BO	CM 116-81	SPEC N	O: SD-688-81	·
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POUECT:	GEAR TRAIN	BACK LASHES	S/N 12VA 527	93			
	BAY CITY	·	·	•		·	
DEP: USS	DURHAM LKA-11	<u>4 · · </u>	NTRACT NO. BCM	116-81 .		SPEC NO: ST	0-688-81
ETICLE NO	583-41-003	PARA, N	io: 3.7.10.49	ÎDR NO:		PH NO:	
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BLOWER DRIVE GEAR	.003	.005	.006	··xx	,		
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ROTOR LEADING EDGE	MIN. 016 MAX. 022	.006	.010		XX	-
ROTOR TO FRONT END PLATE	MIN. 007	.002	.008	XX	••	
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ROTOR TO HOUSING OUTLET	MIN. 005 MAX. 007	.002	.004	••	XX ·	
TIMING GEAR BACKLASH	MIN. 0005 MAX. 004	.0035	.002	XX		

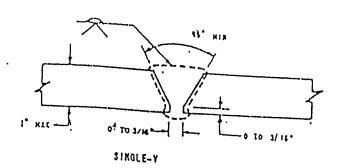
BJECT :	BLOWER"CL	EARANCE S/N	12VA52793 (REA	(R)		
CONTRACTOR:	BAY CITY MA	RINE				
EMIP: USS	DURHAM LKA-11	CONTR.	ACT NO: BCM 11	16-81	SPEC	NO: SD-688-81
ARTICLE NO:	583-41-003	PARA I	NO: 3.7.10.49	IDR NO:	PH· N	Ю:
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CONTRACTOR EMPASURING 1	QC INSP.	DIAL IND,	SUPSHI	IPS REP	3	b6 b7C DATE LAST CALIBRATED 9/10/81
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PART OR PC NO.	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSION	ACCEPT	REJECT	
OTOR TRAILING EDGE	MIN. 002 MAX. 006	.004	.005	XX		
ROTOR LEADING EDGE	MIN. 016 MAX. 022	.006	.010		XX	
ROTOR TO FRONT END PLATE	MIN. 007 MAX. 009	.002	.009	XX	•	
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ROTOR TO HOUSING OUTLET	MIN, 005 MAX. 007	.002	.007	xx ·•		·
FIMING GEAR BACKLASH	MIN. 0005 MAX. 004	.0035	.003	XX		

STEEL PARRICATION CONTROL PROCESSURE NUMBER //// PROME ELE-SET Reference: NAVSEA Standard Items, Item No: 009-13 Vessel Lan-8 (26A) Hull No # 1783 BCM Ja Of 1/6-8/ COMAR Item No. 183-41-003 Pere No 1. Item No. 183-41-003 Pere No 2. Purpose: 12" ACCESS COTS IN ENGINE SPACE * LAZORETTE STACE TO REMOVE ABRASIVE STANTA MATERIAL 3. Welding Process GMAW Welding Position Hokz. 4. Joint Design out of NIL-STD-228 B2V. For Drewing see Enclosure (1) Naximum After Welding Alinement Tolerence for Access Clouwe Joint 5. Base Ketal: ALUMINUM to ALUMINUM Spec QAA-250/12 Gr/01 5076 Thickness S/4 'S' Op S-25 6. Filler Ketal: Sympa 5356 Diameter. 035 'AM Op S-25 6. Filler Hetal: Sympa 5356 Diameter. 035 'AM Op S-25 7. Minimum Proheat Temperature Marinum Interpres Temperature Postweld Heat Treatment or Posthesting: Temperature Simple Procedure 9. Welder shall be currently certified pursuant to NIL-STD-00248 (Ships) 10. Type of Nordestructive Test: Acceptance Standard: VISUAL NSPECTION MARSHES OFFICE OF ACCEPTANCE AND AND HIPS OFFICE OF ACCEPTANCE Standard: NESHIS OFFICE OF AND AND AND AND AND AND HIPS OFFICE OF ACCEPTANCE Standard: NESHIS OFFICE OF AND		AT THE PARTY AND THE		
Reference: NAVSEA Standard Items, Item No: 009-12 Vessel 12M-8 (21) Hull No # 1773 BCM Ja 05-16-8/ Item No. 523-41-003 Para No 1. Item Name RESERVATION Class (KIL-STD-278) 2. Purpose: 12" ACCESS COTE IN ENGINE STACE & LAZARETTE STACE TO REMOVE ABROSIVE BLOSTING MATERIAL 3. Welding Process GM AW Welding Position Hokz. 4. Joint Design out of NIL-STD-228 B2V. For Drawing see Enclosure (1) Haximum after Welding Alinement Tolorence for Access Clasure Joint 5. Base Ketal: ALWAINVM to ALWAINVM Spec Access Clasure Joint 5. Para (21 - 250/19 Gr/Cl 50FG Thickness 5/4 'S* Op S-25 6. Filler Netal: Spec Access 5/4 'S* Op S-25 6. Filler Netal: Spec Access 5/4 'S* Op S-25 7. Ninguas Frehest Temperature Maximum Interpos Temp Postweld Heat Treatment or Posthesting: Temperature Time 8. Welding parameters developed in accordance with PC - 206 7. Ninguas Frehest Temperature Maximum Interpos Temp Postweld Heat Treatment or Posthesting: Temperature Time 8. Welding parameters developed in secondance with Covernment Standard or instruction/WHS/HS 0900-060-90/0 and BC MARINE Welding Procedure 9. Welder shall be currently certified pursuant to NIL-STD-002488 (Shipa) 10. Type of Nondestructive Test: Acceptance Standard: VISUAL NSPECTION MASSHIPS 0900-060-90/0 and BC Marine Procedure	STEEL FABRICATION	- COMPROL PROCEDU	RE -	MACHINE INSTALLATI
Nessel LCM-8 (LEA) Hull NO #6783 BCM JA OF 116-81. COMMY Item No. 283-41-003 Para No 1. Item Name PRESERVATION Class (KIL-STD-278) 2. Purpose: 12" ACCESS CUTS IN ENGINE SPACE & LAZARETTE SIACE TO REMOVE ABRASIVE BLASTING MATERIAL 3. Wolding Process GM AW Welding Fosition Harz. 4. Joint Design out of NIL-STD-22B B2V. Por Drawing see Enclosure (1) Maximum After Welding Althoment Tolorence for Access Closure Joint Spec Access Closure Joint Tolorence for Access Closure Joint Spec Access Closure Joint Tolorence for Access Closure Joint Tolorence Joint Joint Tolorence Joint J	SO46 NEWTON AVENUE	HUMBER //6	4	PHONE 235-8347
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1. Iten Name PRESERVATION Class (NIL-STD-278) 2. Purpose: 12" ACCESS CUTE IN ENGINE SPACE & LAZAREITE SPACE TO REMOVE ABRASIVE BLASTING MATERIAL 3. Welding Process GM AW Welding Position Make. 4. Joint Design out of NIL-STD-22B B2V. Por Drawing see Enclosure (1) Maximum after Welding Alinement Tolorence for Access Closure Joint 5. Base Ketal: ALUMNINM to ALUMNINM Spec QQA-250/19 Gr/Cl 50 Thickness 5/6 SS Gp S-25 Spec QQA-250/19 Gr/Cl 50 Thickness 5/6 SS Gp S-25 Spec QQA-250/19 Gr/Cl 50 Thickness 5/6 SS Gp S-25 Filler Metal: SpecMait-1/05 3 Typa 5356 Dismater 035 *A* Gp S-25 Filler tetal to be handled in accordance with PC-206 7. Ninimum Brokest Temperature Maximum Interpass Temperature Time 8. Welding parameters developed in accordance with Advernment Standard or instruction/NEWINS 0706-060-40/0 MB CC MARINE Welding Procedure 9. Welder shall be currently certified pursuant to NIL-STD-002488 (Ships) 10. Type of Nondestructive Test: Acceptance Standard: VISUAL NSFECTION MASSIES OF ACCORD AND IN ACCEPTANCE Standard for required 2nd organic, Ultrasonic, or Visual imposition of existing weld oxidenting six inches beyond the required outbacks in closure plate openings shall be procedure when a part of welding. 11. A copy of this approved procedure shall be posted at the work location and in the possession of the immediate one for supervisor prior the start of welding. Notes: 10/2/8/				
2. Purpose: 12" ACCESS COTS IN ENGINE SPACE & LAZARETTE SPACE TO REMOVE ABRASIVE BLASTING MATERIAL 3. Welding Process GMAW Welding Position Horz. 4. Joint Design out of NIL-STD-228 BRV. Por Drawing see Emolosure (1) Maximum after Welding Alinement Tolorence for Access Closure Joint 5. Base Ketal: ALUMINUM to ALUMINUM 5. Spec QQA-250/19 Gr/Cl 5076 Thickness 5/16" SS Gp S-25 Spec QQA-250/19 Gr/Cl 5076 Thickness 5/16" SS Gp S-25 5. Filler Metal: Spec/MLE-1605 Type 5356 Diameter 035 AT Gp S-25 Filler Estal to be handled in accordance with Pc/ 206 7. Minimum Proheat Temperature Maximum Interpress Temp Postveld Heat Treatment or Posthesting: Temperature Time 8. Welding persentors developed in accordance with Government Standard or instruction/WES/MPS 0900-006-400/Man BC MARINE Welding Procedure 9. Welder shall be currently certified pursuant to NIL-STD-002488 (Ships) 10. Type of Nondestructive Test: Acceptance Standard: VISUAL ASSECTION MASSIS 0900-060-4010 6. NOT shall be inspected and documented by a person certified to NAVSNIPS 0900-006-8010 and BC Marine Procedure cache tisual and intermediate Dye Penetrant may be conducted by a designated qualified person. 6. Acceptance standard for required Zadiographic, Ultrasonic, or Vinual impection of existing weld extending six inches beyond the required cubacks in closure plate openings shall be crack free. 11. A copy of this approved procedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. 10/2/8/	•			
3. Welding Process GM AW Welding Position Harz. 4. Joint Design out of NIL-STD-22B B 2V. Por Drawing see Enclosure (1) Maximum After Welding Alinement Tolorence for Access Closure Joint 5. Base Ketal: ALUMINUM to ALUMINUM Spec QQA-250/9 GF/Cl 5076 Thickness 5/4 "5" Gp S-25" 6. Filler Metal: SpecALL-1/0.5 Type 5356 Diameter.035 "A" Gp S-25" 6. Filler Metal: SpecALL-1/0.5 Type 5356 Diameter.035 "A" Gp S-25" 7. Minimum Pruheat Temperature Maximum Interpres Temp Postweld Heat Treatment or Posthesting: Temperature Time 8. Welding persentors developed in accordance with Government Standard or instruction/WESMPS 0900-060-40/Oand SC MARINE Welding Procedure 9. Welder shall be currently certified pursuant to NIL-STD-002488 (Ships) 10. Type of Nondestructive Test: Acceptance Standard: VISUAL NSFECTION MARINES 0900-060-40/O a. NDT shall be inspected and documented by a person certified to NAVSHIPS O900-066-8010 and BC Marine Procedure. Acceptance Standard: VISUAL NSFECTION MARINES 0900-060-40/O a. NDT shall be inspected and documented by a designated qualified person. b. Acceptance standard for required Endioraphic, Ultrasonic, or Visual impocition of existing weld extending six inches beyond the required cutbacks in closure plate openings shall be crack free. 11. A copy of this approved procedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding.	• "			
3. Welding Process GM AW Welding Position Hokz. 4. Joint Design out of NIL-STD-228 82V. For Drawing see Enclosure (1) Maximum After Welding Alinement Tolerence for Access Cleave Joint 5. Base Ketal: ALUMINUM to ALUMINUM Spec QQA-250/19 Gr/Cl 5076 Thickness 5/16 "S" Op S-25 to Spac QQA-250/19 Gr/Cl 5076 Thickness 5/16 "S" Op S-25 6. Filler Ketal: SpecMin-1005 Type 5356 Diameter 035 "A" Op S-25 Filler Estal to be handled in accordance with Pcl 206 7. Minimum Brohest Temperature Maximum Interpaes Temp Postweld Heat Treatment or Posthesting: Temperature Time 8. Welding perameters developed in accordance with Government Standard or instruction/WHEMPS 0900-060-40/0and 8C MARINE Welding Procedure 9. Welder shall be currently certified pursuant to NIL-STD-002488 (Shipa) 10. Type of Nondestructive Test: Acceptance Standard: VISUAL NSPECTION MARINES 0900-060-4010 6. NOT shall be inspected and documented by a person certified to NAVSHIPS 0900-060-8010 and BC Marine Procedure except visual and intermediate Dye Penetrant may be conducted by a designated qualified person. b. Acceptance standard for required Endicrophic, Ultrasonic, or Visual inspection of existing weld extending six Inches beyond the required cutbacks in closure plate openings shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notas: Notas:		•		•
4. Joint Design out of MIL-STD-22B BRV. Por Drawing see Enclosure (1) Maximum After Welding Alimement Tolerence for Access Cleaure Joint 5. Base Ketal: ALUMINUM to ALUMINUM Spec QQA-250/19 Gr/Cl 5086 Thickness 5/16 "S" Gp S-25 to Thickness 5/16 "S" Gp S-25 6. Filler Ketal: SpecMM:E-14053 Type 5356 Diameter 035 "A" Gp S-25 Filler Estal to be handled in accordance with P2/206 7. Minimum Proheat Temperature Meximum Interpros Temp Postweld Heat Treatment or Posthesting: Temperature Time 8. Welding parameters developed in accordance with Covernment Standard or instruction/MISMMS 0900-060-40/Oand BC MARINE Welding Procedure 9. Welder shall be currently certified pursuant to MIL-STD-002498 (Shipa) 10. Type of Nondestructive Test: Acceptance Standard: VISUAL NSPECTION MISMMS 0900-060-40/O a. NDT shall be inspected and documented by a person certified to NAVSHIPS 0900-060-8010 and BC Marine Procedure , except visual and intermediate Dye Penetrant may be conducted by a designated qualified person. b. Acceptance standard for required Endicomphic, Ultrasonic, or Visual inspection of existing weld extending six inches beyond the required cutbacks in closure plate openings shall be crack free. 11. A copy of this approved procedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notas:	STACE TO RET	NOVE ABRASTV	E BEASTING	G MATERIAL
4. Joint Design out of NIL-STD-22B BRV. Por Drawing see Enclosure (1) Maximum After Welding Alinement Tolerence for Access Cloque Joint 5. Base Ketal: ALUMINUM to ALUMINUM Spec QQA-R-250/19 Gr/Cl 5086 Thickness 5/16 "S" Gp S-25 to Spec QQA-250/19 Gr/Cl 5086 Thickness 5/16 "S" Gp S-25 6. Filler Metal: SpecMM:E-14053 Type 5356 Diameter.035 *A" Gp S-25 Filler metal to be handled in accordance with PC1.206 7. Minimum Proheat Temperature Maximum Interpress Temp Postweld East Treatment or Posthesting: Temperature Time B. Welding parameters developed in accordance with Covernment Standard or instruction/WESMPS 0900-060-40/Oand BC MARINE Welding Procedure 9. Welder shall be currently certified pursuant to NIL-STD-002498 (Shipa) 10. Type of Nondestructive Test: Acceptance Standard: VISUAL NSPECTION MESMITS 0900-060-40/O a. HDT shall be inspected and documented by a person certified to NAVSHIPS 0900-066-8010 and BC Marine Procedure , excent visual and intermediate Dye Penetrant may be conducted by a designated qualified person. b. Acceptance standard for required Endicoraphic, Ultrusonic, or Visual inspection of existing weld extending six inches beyond the required cutbacks in closure plate openings shall be crack free. 11. A copy of this appraved procedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notes:	* ************************************			2 2 2
See Retal: ALUMINUM Spec 40-A-250/19 Gr/Cl 50-F6 Thickness 5/16 "S" Gp S-25 Spec 40-A-250/19 Gr/Cl 50-F6 Thickness 5/16 "S" Gp S-25 6. Filler Ketal: SpecMix-F-160-S Type 53-56 Diameter.03-S "A" Gp S-25 Filler Estal to be handled in accordance with Pc/ 20-6 7. Ninimum Preheat Temperature Meximum Interpace Temp Postweld Reat Treatment or Posthesting; Temperature Time 8. Welding parameters developed in accordance with Covernment Standard or instruction/NNSMINS 0900-060-40/Oand &C MARINE Welding Procedure 9. Welder shall be currently certified pursuant to NIL-STD-002498 (Ships) 10. Type of Nondestructive Test: Acceptance Standard: VISUAL NSPECTION MARSHITS 0900-060-40/O a. HDT shall be inspected and documented by a person certified to NAVSHIPS 0900-06-8010 and BC Marine Procedure , except visual and intermediate Dye Penetrant may be conducted by a designated qualified person. b. Acceptance standard for required Endicomphic, Ultrasonic, or Visual impection of existing weld extending six inches beyond the required cutbacks in closure plate openings shall be crack free. 11. A copy of this approved precedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notes:	• • • • • • • • • • • • • • • • • • • •			
Spec QQA - 250/19 Gr/Cl 5086 Thickness 5/6 "S" Gp S-25 to Spec QQA - 250/19 Gr/Cl 5086 Thickness 5/6 "S" Gp S-25 to Spec QQA - 250/19 Gr/Cl 5086 Thickness 5/6 "S" Gp S-25 to 6. Filler Metal: Spec Mu: F-16053 Type 5356 Dismeter. 035 "A" Gp S-25 Filler Estal to be handled in accordance with Pc/ 206 7. Minimum Freheat Temperaturo Meximum Interpress Temp Postweld Heat Treatment or Posthesting: Temperaturo Time 8. Welding parameters developed in accordance with Covernment Standard or instruction/NNSMPS 0900-060-40/0 and BC MARINE Welding Procedure 9. Welder shall be currently certified pursuant to NIL-STD-002488 (Ships) 10. Type of Nondestructive Test: Acceptance Standard: VISUAL NSPECTION MOSTALL OF Procedure , except visual and intermediate Dyp Penetrunt may be conducted by a person certified to NAVSHIPS 0900-006-8010 and BC Marine Procedure , except visual and intermediate Dyp Penetrunt may be conducted by a designated qualified person. b. Acceptance standard for required Endiographic, Ultrasonic, or Visual improcution of existing weld extending six inches beyond the required cutbacks in closure plate openings shall be crack free. 11. A copy of this approved procedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notes:	4. Joint Design out of MIL Maximum After Welding A	-STD-22B <u>B2V.</u> linement Tolerence	for Draw	ing see Enclosure (1)
Spec QQA - 250 / 19	5. Base Ketal: ALUMIA	10 m to	AZUMINU	M
6. Filler Metal: Spec. Mar. F-14053 Type 3356 Diameter. 035 AT Cp 5-25 Filler metal to be handled in accordance with Pc1. 206 7. Minimum Freheat Temperature Maximum Interpass Temp Postweld Heat Treatment or Posthesting: Temperature Time 8. Welding parameters developed in accordance with Government Standard or instruction WASSANS 0900-060-4010 and BC MARINE Welding Procedure 9. Welder shall be currently certified pursuant to MIL-STD- 00248B (Ships) 10. Type of Nondestructive Test: Acceptance Standard: VISUAL NSPECTION MASSANS 0900-060-4010 a. HDT shall be inspected and documented by a person certified to NAVSHIPS 0900-006-8010 and BC Marine Procedure except visual end intermediate Dye Penetrant may be conducted by a designated qualified person. b. Acceptance standard for required Endiomanhie, Ultrasonic, or Visual inspection of existing weld extending six inches beyond the required cutbacks in closure plate openings shall be crack free. 11. A copy of this approved procedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notes:	Spec 99-A- 250/19	Gr/Cl .5086	Thickness	5/16 "S" Gp <u>S-25</u> 5
6. Filler Metal: Spec. Mar. F-14053 Type 3356 Diameter. 035 AT Cp 5-25 Filler metal to be handled in accordance with Pc1. 206 7. Minimum Freheat Temperature Maximum Interpass Temp Postweld Heat Treatment or Posthesting: Temperature Time 8. Welding parameters developed in accordance with Government Standard or instruction WASSANS 0900-060-4010 and BC MARINE Welding Procedure 9. Welder shall be currently certified pursuant to MIL-STD- 00248B (Ships) 10. Type of Nondestructive Test: Acceptance Standard: VISUAL NSPECTION MASSANS 0900-060-4010 a. HDT shall be inspected and documented by a person certified to NAVSHIPS 0900-006-8010 and BC Marine Procedure except visual end intermediate Dye Penetrant may be conducted by a designated qualified person. b. Acceptance standard for required Endiomanhie, Ultrasonic, or Visual inspection of existing weld extending six inches beyond the required cutbacks in closure plate openings shall be crack free. 11. A copy of this approved procedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notes:	Spec QQA - 250/19	Gr/Cl <u>5086</u>	Thickness	5/16 is Op 5-25
7. Minimum Irwheat Temperature Maximum Interpass Temp Postweld Heat Treatment or Posthesting: Temperature Time 8. Welding parameters developed in accordance with Covernment Standard or instruction/NANSHIPS 0900-060-40/0 and BC MARINE Welding Procedure 9. Welder shall be currently certified pursuant to MIL-STD- 002488 (Ships) 10. Type of Nondestructive Test: Acceptance Standard: Note	6 Dillon Watale			•
7. Minimum Irwheat Temperature Maximum Interpass Temp Postweld Heat Treatment or Posthesting: Temperature Time 8. Welding parameters developed in accordance with Covernment Standard or instruction/NANSHIPS 0900-060-40/0 and BC MARINE Welding Procedure 9. Welder shall be currently certified pursuant to MIL-STD- 002488 (Ships) 10. Type of Nondestructive Test: Acceptance Standard: Note	Filler metal to be hand	led in accordance	with Pcl. 20	26 1
struction/NAISHIPS 0900-060-40/0 and BC MARINE welding Procedure 9. Welder shall be currently certified pursuant to NIL-STD-002488 (Ships) 10. Type of Nondestructive Test: Acceptance Standard: NOT shall be inspected and documented by a person certified to NAVSHIPS 0900-006-8010 and BC Marine Procedure except visual and intermediate Dye Penetrant may be conducted by a designated qualified person. b. Acceptance standard for required Endiographic, Ultrasonic, or Visual inspection of existing weld extending six inches beyond the required cutbacks in closure plate openings diall be crack free. 11. A copy of this approved procedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notes: 10/2/S/				
a. NDT shall be inspected and documented by a person certified to NAVSHIPS 0900-006-8010 and BC Marine Procedure , except visual and intermediate Dye Penetrant may be conducted by a designated qualified person. b. Acceptance standard for required Endiographic, Ultrasonic, or Visual inspection of existing weld extending six inches beyond the required cutbacks in closure plate openings shall be crack free. 11. A copy of this approved procedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notes:				
NOT shall be inspected and documented by a person certified to NAVSHIPS 0900-006-8010 and BC Marine Procedure, excent visual and intermediate Dye Penetrant may be conducted by a designated qualified person. b. Acceptance standard for required Endicy Taphic, Ultrasonic, or Visual inspection of existing weld extending six inches beyond the required cutbacks in closure plate openings thall be crack free. 11. A copy of this approved precedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notes:	'9. Welder shall be current	ly certified pursu	ant to NIL-STI	0- 00248B (Shipa)
a. NDT shall be inspected and documented by a person certified to NAVSHIPS 0900-006-8010 and BC Marine Procedure , except visual and intermediate Dye Penetrant may be conducted by a designated qualified person. b. Acceptance standard for required Endiographic, Ultrasonic, or Visual inspection of existing weld extending six inches beyond the required cutbacks in closure plate openings shall be crack free. 11. A copy of this approved procedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notes:	10. Type of Nondestructive	Test:	Acceptanc	e Standard:
0900-006-8010 and BC Marine Procedure , excent visual and intermediate Dye Penetrant may be conducted by a designated qualified person. b. Acceptance standard for required Endiographic, Ultrasonic, or Visual inspection of existing weld extending six inches beyond the required cutbacks in closure plate openings shall be crack free. 11. A copy of this approved procedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notes:	VISUAL INSPEC	TIÖN	NAUSHITS O	900-060-4010
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b. Acceptance standard for required Endiographic, Ultrasonic, or Visual inspection of existing weld extending six inches beyond the required cutbacks in closure plate openings shall be crack free. 11. A copy of this approved precedure shall be posted at the work location and in the possession of the immediate on site supervisor prior the start of welding. Notes:	0900-006-8010 and BO	Marina Procedu	re 🧢 , excent	t visual and inter-
the possession of the immediate on site supervisor prior the start of welding. Notes:	inspection of exist.	ing weld extending	six inches bey	yond the required
10/2/8/	11. A copy of this approve the possession of the	d precedure shall immediate on site	be posted at t supervisor pri	he work location and in or the start of welding.
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HULL 6765 12" ACCESS CUTS HULL 6783

' MIL-STD-0022C(лн) ·· 29 'August 1977 ·

B27.1



ENCL. 3

	ER OF TRANSMITTAL No. LOT 11
BAY CITY MARINE, INC	Contract: 316.81 Date: 10.16.40
1411 Harding Avenue	
National City, CA 92050	Vessel: Hull:
TO: Supervisor of Shipbuilding	iltem: Sas-si -DSS Mod.
Conversion and Repair, USN U.S. Naval Station; Box 119 San Diego, California 92136	Spec. S/D 685-81
	Reference:
1809-10	
Attn: Code #	
☐ Required Report(s)	Enclosure(s):
☐ Schedule of Events	AS FOUND REPORT
☐ Excess Material	
☐ Supships S/ > 4500/2	
☐ Drawing(s)	
☐ Test Memo	
☐ J.O. Exception(s) Completed	
Comments:	
<u> </u>	
DAY OLTY MADINE INC	Supships
BAY CITY MARINE, INC.	Substitiba

LOWER STED RUB RAIL - CROPOUT 17'AFT & 1'6" FWD. UPPER PORT RUB RAIL-CROP-OUT 15'AFT & 12'6" FWD. 46 total 150 LIN FT PORT SIDE RAMP SQ. STOCK-CROP-OUT APPROX 4" & RENEW COUNT FROM FUD #4 9 #8 BOHOM-4 CRACKS IN /AZ (2 PORT & 2 STBD) V-OUT & WELD ON 2, APPROX 6" long - INSERT I witH 6" DIA INSERTS USING BACK-UP STRIPS. 100 Sq F &. FWD STBD RAMP CORNER-C/AD WELD APPROX 8" STED RAMP SHEEVE COVER & RAMP AREA- APPROX 1 SQ.FH. REPLACE & REPAIR. 20 SQ. Ff. STED: AFT COPNER - CROPOUT & PENEW DAMAGED AREA, APPROX 16"x 24" 100 SR.Ff.

PORT-SKEG-CROPOLT & RENEW MOST FWD. END 36".
APPROX 16"x 24" AFT. 100 SQ-FT.

MAG PART OR UT IS STRUTS. Ut EnHom FLT FROM MIDSHIP TO FRES OUTEDARD STRAKES.

28 W/MACHAE

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NATIONAL PUMP & INJECTOR SALES & SERVICE, INC.

2307 East Belt'Street

San Diego, California 92113

Phone: Area Code 714, 232-0831

October 14, 1981

Bay City Marine 1411 Harding Avenue National City, Calif 92050

73.50

Subject: U.S.S. Durham LKA-114 BCM 116-81, Spec #688-81 Item #583-41-004, LCM'8 2 each 12V71 G.M. Diesel Engines, S/N 12VA53220

S/N 12VA53217

Gentlemen:

The following conditions were noted and recorded during the disassembly, cleaning and inspecting of subject engines.

Engine S/N 12VA53220

Crankshaft cracked (See NDT Report). Crankshaft scored. Right exhaust manifold broken. Right bank thermostat housing broken. Water temp and fuel oil pressure sending units broken. Engine lube oil contaminated with fuel oil. Fuel oil jumper lines damaged. Both valve covers damaged. Blower coupling damaged. Blower drive gears rusty and pitted. Blower coupling cover damaged.

Trasmission & P.T.O.

Bearings worn and scored. Forward clutch plates worn and warped. Forward clutch springs broken.

Missing Parts Report

Generator, RPA Hydraulic pumps.

Engine S/N 12VA53217

Crankshaft worn beyond manufacture wear limits. Cam rollers worn and scored. Vibration dampner damaged.

* Bay City Marine

Page #2

Continue

Transmission & P.T.O.

Forward clutch springs broken. Reverse springs broken. Bearings worn and scored. Forward and reverse clutch plates worn and warped.

Missing Parts Report

Generator, RPA Hydraulic Pumps.

Recommend the following list of material be repaired and or replaced

1 1 1	5146734 5162715 5172628	CRANKSHAFT RIGHT BANK EXHAUST MANIFOLD RT BANK THERMOSTAT HOUSING
12	5111527	FUEL OIL JUMPER LINES(L)
1	5103744	NALVE COVERS
2	5149512	VALVE COVER INST KITS
1	5103377	BLOWER COUPLING
1	5196763	BLOWER COUPLING COVER
12	5111526	FUEL OIL JUMPER LINES (S)

35.25

Transmission

1	MA648	BALL BEARING
1	MA647	ROLLER BEARING
2	M2175B	BALL BEARING
2	M2104	BALL BEARING
2	MA 6 4 9	BALL BEARING
1	M2475A	BALL BEARING
2	MA293	BALL BEARING
1	M2167	BALL BEARING

Engine S/N 12VA53217

(NONE)

Bay City Marine

Page #3

Continue

Transmission

1 1 2 2 2 2 1 2	MA648 MA647 M2175B M2104 MA649 M2475A MA293	•	BALL BEAR BEARING, I BALL BEAR BALL BEAR BALL BEAR BALL BEAR BALL BEAR BALL BEAR	ROLLER ING ING ING ING ING
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4	PEHETR	ANTS				IING	3 H 1/4	<u>-:/</u>							Part Name: DROTHE TAKES Quantity: FOUR (4) EACH
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CONTRACT	OR:	BAY CITY MA	ARINE			•		
		DURHAM LKA-JJ		CONTRACT N	o: BCM	A 116-81	SPEC NO	SD 688-81
ARTICLE	NO:	583-41-004	PAKA NO:	3.7.10.49	IDI	R NO:	P11 NO:_	
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SULECT:	CYLINDER BLO	CK BORES (LE	FT BANK) S/N 12	VA53220		
CONTRACTOR:	BAY CITY	MARINE		•		
CMIP: USS	PURHÁM LKA-114	CC	ONTRACT NO: BC	M 116-81	SPEC NO:	SD 688-81
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SUBJECT:	CRANKSHAFT M	IAIN BEARING J	OURNALS	S/N	12VA53220			
	BAY CITY I				•			
SHIP: US	SS DURHAM LKA-	114 co	ONTRACT	NO: BCM 116-81 SPEC NO: SD-688-81				SD-688-81
	583-41-004							
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SUBJECT:	-CONNECTING	ROD JOURNALS	S/N 12VA53	270		
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SUBJECT:	CAMSHAFT BEA	RING JORNALS	RIGHT S/	N 12VA	53220		, . ,,	
	BAY CITY							
SHIP: USS	S DURMAM LKA-1	14 CONT	RACT NO:	BCM 11	6-81	SPEC	ńo: St	688-81
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SUBJECT:	CAMSHAFT BEA	TAMO TORNATO	· S/N 121	/A5322	O (LEFT)		
CONTRACTOR	BAY CITY	MARINE				****	
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SECT:	END THRUST	CRANKSHAET,	CAMSHAFT, BALL	INCESHAFT .	S/N 12VA5322	. <i>u</i>	
TRACTOR	BAY CITY	MARINE S		•			
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ASURING :	Instrument us	ED DIAL IND.	. CONTEC	OL NO: D 1-3	CALI	BRATED_9/1	1/81
·	EADINGS AS FOL	IND		GALIBI	ATION HARK	ED (YES)	NO ·
CAT OR G NO.	REFERENCE DIMENSION	REFERENCE TOLERANCE		ACCEPT	REJECT		
eank- eapt	.004 .011	.007	.008	х́х ·			
MALE TARE	.004	.008	.011	· XX			
alance– Papt	.004	.008	.010	XX ·	•		
	ż			,		·	
					·		
octors (

SUBJECT:	BLOWER CLE	ARANCE S/A	<u> 12VA 53220 [F</u>	-RONT)		
	" RAV CITY M		ŧ			
•			ICT NO: BCM 1	16-81	SPEC	NO: SD-488-81
•	583-41-004	•				
·		•			•	
)/OR PLAN AND/ G WEAR LIMITS	•	•			
MIC				• .	`÷	Col.
· · · · · · · · · · · · · · · · · · ·						
						ъ6 ъ7С
CONTRACTOR	•			IPS REP.		DATE LAST
MEASURING 1	instrument ü se	DIAL IND. FEELER GAUG	CONTR	ol No D 1-	3	CALIBRATED/10/8
	DINGS AS FOUND					_
PART OR	REFERENCE	REFERENCE				·
PC NO.	DIMENSION	LULERANUS	NO3 Creates a			
	MIN. 002 MAX. 006	.004	.006	xx		
ROTOR	·					
LEADING EDGE	MIN. 016 MAX. 022	.006	.009		xx	
ROTOR TO						
FRONT END PLATE	MIN. 007 E MAX. 009	.002	.008	XX	••	
ROTOR TO						
REAR END PLATE	MIN. 007 E MAX. 009	.002	.015		XX	
ROTOR TO		.002	.014		Xx	•
HOUSING INLET SID	MIN. 017 DE MAX. 019					
ROTOR TO		.002	.006	, XX ·•		
HOUSING OUTLET	MAX. 007					
TIMING	MIN OOOS					
GEAR BACKLASH	MIN. 0005 MAX. 004	.0035	.003	XX		

DIBJECT:	BLOWER" CLI	EARANCE S	/N 12VA 5322	O (REAR)		
CONTRACTOR:	· BAY CITY I	IARTNE				
SHIP: USS	DURHAM LKA-114	CONTR	ACT NO: BO	M J16-81	SPEC	: NO: SD 688-81
AMTICLE NO:	583-41-004	PARA	NO: 3.7.10.	49 IDR NO:	PH-N	ю:
MAVSHIP AND	OOR PLAN AND/	or sketch re	PERENCE:			
	MFG WEAR LIMIT	rs .	_			
				•	·	<
]	,		b6
CONTRACTOR	QC INS		SUP	SHIPS REP.		
		ED DTAI THO	CON	TROL NO n 1		DATE LAST CALIBRATED
	NGS AS FOUND	FEELER GAUG				
PART OR	REFERENCE	REFERENCE) MEASURED	CALIBRATION	MARKED &	CES NO
PC NO.	DIMENSION	TOLERANCE	DIMENSION	· ·	REJECT	
ROTOR TRAILING EDGE	MIN. 002 MAX. 006	. 004	.010		XX	
ROTOR LEADING EDGE	MIN. 016 MAX. 022	.006	.008.		XX	
ROTOR TO FRONT END PLATE	MIN. 007 MAX. 009	. 002	.016		XX*	
ROTOR TO REAR END PLATE	MIN. 007 MAX. 009	.002	.008	XX		
ROTOR TO HOUSING INLET SID	MIN. 017 E MAX. 019	. 002	.012		XX	•
ROTOR TO HOUSING OUTLET	MIN. 005 MAX. 007	.002	.006	хх ••		
TIMING GEAR BACKLASH	MIN. 0005 MAX. 004	.0035	.001	XX		

EPORT NO. 200

ubject :	GEAR TRAIN E	IACK LASIIES	S/N'12VA 53220		·	
TRACTOR:	BAY CITY MAR	ÎNE		• •		
				116-81		SPEC NO: SD-688-81
•	583-41-004					PM NO:
'. A vship an d	OR PLAN AND		FERENCE			•
٠.	MFG WEAR LIN	_	:		•	•
<u> </u>						
						14
	oo ruch	Ī	CHECHI	PS REP.		b6 b7C
ONTRACTOR	•		301.001	PS REP.	D	ATE LAST ALIBRATED 9/10/81
		U VIAL IND.	CONTRO	10 · 1 1 ·	3	9/30/81
KEAVIN	IGS AS FOUND			RATION MARK	ED YES) мо
PART OR PC NO.	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSION	ACCEPT	REJECT	
CAM TO" CAM SEAR	.003 .008	.005	.005	XX		
R. CAM IDLER TO GEAR	.003	.005	. 00.4	xx ···		
TDLER TO CRANK- SHAFT GEAR	.003	.005	.005	XX	4.	
BLOWER DRIVE GEAR	.003	.005	.008	.xx	•	
			•	-1		·
					•	·

	Physic !	,,	STORAL THEFT DOT			
	••		RIGHT BANK) S/N	12VA43217		
CONTRACTOR:	BAY CITY MARI	NE ·		•		
CMIP: USS	DURHAM LKA -1	14 C	ONTRACT NO: BCM	116-81	SPEC NO	SD -688-81
ARTICLE NO:	583-41-004	PARA NO:_	3.7.10.49 ID	R NO:	Pit HO:_	
			EFERENCE			
		•	AR LIMITS			
		*		•	10	
						b6
CONTRACTOR	QC II		SUPSE	IIPS REP.	DATE	b7C LAST 8_2/6_81
MEASURING I	NSTRUMENT USE	BORE GAUGES	SUPSH	DBG -	CALII	RATED
	•		•			
READINGS PART OR	AS FOUND REFERENCE	REFERENCE	MEASURED	CAI	IBRATION HA	RKED (YES) NO
	DIMENSION	TOLERANCE	DIMENSION	ACCEPT	REJECT	
#1 CYLINDER	4.6265 4.6275	.001	T. 4.6273 M. 4.6271 B. 4.6268	XX XX XX		
#2 CYLINDER	4.6265 4.6275	.001	T. 4.6272 M. 4.6273 B. 4.6270	XX XX XX		
f3 CYLINDER	4.6265 4.6275	.001	T. 4.6274 M. 4.6271 B. 4.6271	XX XX XX	٠.	
04 CYLINDER	4.6265 4.6275	.001	T. 4.6270 M. 4.6271 B. 4.6268	XX XX XX		
05 CYLINDER	4.6265 4.6275	.001	T. 4.6275 M. 4.6273 B. 4.6268	XX XX XX	, •	
16 CYLINDER	4.6265 4.6275	.001	T. 4.6272 M. 4.6271 B. 4.6269	XX XX		
- Management of the Control of the C						

	A44 Thurston B1/1	ACK BARES	(LEFT BANK)	S/N 12VA33217		
	CYLINDER BLO			•		
NTRACTOR:	BAY CITY MAI	RINE				
· USS D	URHAM LKA-114	4	3.7.10.49	CM 116-81	CARC NO.	SD 688-81
IP:	<u>i.</u>		CONTRACT NO:		SPEL NO:	
TTCIP NO.	583-41-004	OM AUAG	3./.10.49	R NO:	Pti 180:	
VSHIP AND	OR PLAN ANI	O/OR SKETCH	REFERENCE			
		MFG. W	EAR LIMITS		•	•
			· · · · ·	· · · · · · · · · · · · · · · · · · ·	 	
		•				
			-			
						b6
			ÉUPS	HIPS REP.		b7C
ENTRACTOR	QC INS				DATE	LAST 0 0/ 91
KASIIDIMA T	NSTRIMENT US	ED BORE GAUG	SES CONT	ROL NG. DBG -	CALIB	LATED 8-24-81
	•		•			
DEADINGS	AS FOUND		,	CAT	TRRATTON MA	RKED (YES)
		REFERENCE	MEASURED		TENATION INC	LACED (S.E.S. /
	REFERENCE DIMENSION	TOLERANCE		ACCEPT	REJECT	
C NO.	Dillaro					
	4.6265		т. 4.6274	XX	,	
CYLINDER	4.6275	.001	M. 4.6272	XX		
			B. 4.6265	XX XX		
40	4.6265		T. 4.6270	XX		
	4.6275	.001	M. 4.6270 B. 4.6268	XX		
CILINDER	4.02.0		В. 4.0200			**************************************
			T. 4.6272	XX		
# 3	4.6265	.001	M. 4.6271	XX		
CYLINDER	4.6273	.001	B. 4.6271	XX	•	
			T. 4.6272	XX		
04	4.6265		M. 4.6272	XX		
CYLINDER	4.6275	.001	B. 4.6271	XX ·		
_					-	
	1 1265		т. 4.6273	. xx	. •	-
45	4.6265	.001	M. 4.6272	XX		
CYLINDER	4.02/3	.001	B. 4.6270	XX		
	<u> </u>	 		777		
# 6	4.6265		T. 4.6274	XX XX ·	1	
CYLINDER	4.6275	.001	M. 4.6272	XX	1	
)			В. 4.6266	ΛΛ.		
		•				
				1		

SUBJECT:	CONNECTING	ROD JOURNALS	CRA	NKSHAFT	S/N 12	VA53217	
	BAY CITY 1				•		
SHIP: USS	DURHAM LKA 1	14 CONTR	ACT NO:	BCM	116-81	SPEC	NO: SD 688-81
ARTICLE NO	:583-41-004	PARA	NO:	.10.49	IDR NO:	PM N	0:
NAVSHIP AN	D/OR PLAN AND						14
							ь6 b7С
CONTRACTOR	QC INSP.			SUPSHI	PS REP.		
CONTRACTOR QC INST. MEASURING INSTRUMENT USED 2-3" mic					L NO. 21		DATE LAST CALIBRATED 9-10-81
	READINGS AS FO	ממווכ		C	ALIBRATION	MARKED (Y	es) no
	REFERENCE DIMENSION	REFERENCE	MEASU	RED	ACCEPT	REJECT	
#1	2.999 3.000	.001	2.999		_ xx		,
#2	2.999	.001	2.999		XX		
//3	2.999	.001	2.999	٠ ,	ХХ		
#4	2.999	.001	2.999		хх	•	
# 5	2.999	.001	2.999		. XX	, .	
#6	2.999 3.000	.001	2.999	• 1	XX		·
					··	••	

SUBJECT:	CRANKSHAFT 1	AAIN BEARING J	OURNALS	s/N	12VA53217				
CONTRACTOR	BAY C	ITY MARINE				···			·
Shir: USS	DURHAM	C	ONTRACT NO:	i	BCM 116-81	SI	PEC NO:	SD 688-8	31
		4. P.							
		or sketch re							
		., MFG WEAD						' 4	
			7						
CONTRACTOR	OC INSP		SIII		PS REP.		·	·	b6 · b7C
MEASURING	TNSTRUMENT US	ED MICROMETER	4-5" CON	JTRO	M1-5	DATE	LAST	9-10-81	
,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	,		,	1110	D 1101	ONDI	, <u>,</u>	*	
	S AS FOUND	/ nepenguer			CALIBRATIO	MARKED (YES)	ИО	
C NO.	DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSION		ACCEPT	REJECT	-		
#1	4 .499 4 .500	.001	4.4985	;		xx			
#2	4 ² : 499 - 4 : 500	.001	4.4985	;		XX			
#3	4.499 4.500	.001	4.499		XX				
#4	4.499 4.500	.001	4.4985	,		ХХ			
# 5	4.499 4.500	.001	4.498			XX		***************************************	
# 6	4.499 4.500	.001	4.4985	•		XX		•	
3 1	4.499 4.500	.001	4.499		XX.			******	

Company of the Section 2

	•	DIMENS	IONAL INSPECTI			•
	CAMSHAFT .			12VA53217	· · _ · · · · · · · · · · · · · ·	
CONTRACTOR	BAY CITY	MARINE		······		
SHIP: USS	DURHAM LKA	-114 CONT	RACT NO: BCM	116-81	ŠPEC N	O:SD 688-81
ARTICLE NO	583-41-00	4 PARA NO: 3	.7. 10.49	IDR NO:	PM NO:	
NAVSHIP AN	D/OR PLAN ANI	D/OR SKETCH R	EFERENCE		٠,,	- Company - Comp
		MFG W	EAR LIMITS	-		
	•		,	•		
]		· · · · · · · · · · · · · · · · · · ·	
CONTRACTOR	OC INCI		cincu	The pro		ь6 ь7с
	INSTRUMENT US:	1-2" mic	•	ol no. D1-3	TO A CT	IS Y ACTO
MEASURING	INSTRUMENT US	ED	CONTR	OL NO.	CAL	IBRATED
	INGS AS FOUND			CALIBRATI	on marked ((YES) NO
	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSION	ACCEPT	REJECT	
FRONT END JOURNA	1.4970 1.4975	.0005	1.496	٠	xx	
INTERMEDIA #1	TE 1.4980 1.4985	.0005	1.497		XX ,	
#2	1.4980 1.4985	.0005	1.496		ХХ	
#3	1.4980 1.4985	.0005	1.497	·	хх	
#4	1.4980 1.4985	.0005	1.497	·	xx	
# 5	1.4980 1.4985	.0005	1.497	.,	XX · · · · · ·	•
REAR END	1.4970 1.4975	.0005	1.496	. 41 .	XX	The state of the s

DHFT		
SUBJECT: CAMSHAFT S/N 12V	Ά53217 ¹	
CONTRACTOR: BAY CITY MARINE		
SHIP: USS DURHAM LKA -114 CONTRACT NO:	BCM -116-81	SPEC No: SD 688-81
ARTICLE NO: 583-41-004 PARA NO: 3.7.10.49	IDR NO:	PM NO:
NAVSHIP AND/OR PLAN AND/OR SKETCH REFERENCE MFG. WEAR I	· · · · · · · · · · · · · · · · · · ·	· .
		-b6
CONTRACTOR QC I	SUPSHIPS REP.	
	CONTROL NO. M1-22	DATE LAST 9-10-81 CALIBRATED
READINGS AS FOUND .	CALIBRATION MA	ARKED (YES) NO

4	ADINGS AS FOOD		CALIBRATION MARKED YES NO			
PART OR PC NO.	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSION	ACCEPT	REJECT	
FRONT END CAM JOURNA	1.4970 1.4975	.0005	1.497	XX		
INTERMEDIA'	TE 1.4980 1.4985	.0005	1.496	-	XX	
#2	1.4980 1.4985	.0005	1.497		XX	
#3	1.4980 1.4985	.0005	1.497		ХХ	
#4	1.4980 1.4985	.0005	1.497		хх	
# 5	1.4980 1.4985	.0005	1.497		XX	•
REAR END CAM JOURNA	1.4970 1.4975	.0005	1.4965		XX	

YECT: 4	END THRUST,	CRANKSHAFT,	CAMSHAFT.	S/N 12VA53217		٠
FRACTOR	BAT CITY	MARINE				•
	DURHAM TKA11A"		CONTRACT NO:_	BCM 116-81	SPEC N	SD 688-81
ICLE NO	583-41-004	PARA. NO.	3.7.10.49	IDR NO.	PM NO.	•
						•
	ID/OR PLAN AND	MFG. WEAR LIM	ITS.		•	;
		· · · · · · · · · · · · · · · · · · ·	*			
2722		Ţ		. b6 , b7С		
FRACTOR	QC INS		sups	HIPS REP,	*	•
SURING	INSTRUMENT US	DIAL IND	CONT	FOL NO:	_ DATE	LAST 9/10/81
	NGS AS FOUND			:	•	ED (YES) NO
ART OR	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSION	ACCEPT	REJECT	
ANK- IAPT	.004	.007	.005	xx ·		
M-R	.004	.008	.010	XX '		
(L	.004	.008	.011	XX.	_	
- A Silver Control of the Control of	£			•		·.
	·					
•						

.UDJECT:	GEAR TRAIN B	ACK LASHES	s/N 12VA532	217		
STRACTOR:	BAY CITY MAR	ine	u.			
		-114 CO	NTRACT NO. BCM	116-81	····	SPEC NO:SD 688-81
•	583-41-004	_•				
g w	o/or plan and/					
••	1	•	AR LIMITS		,	•
A1774 THE TOTAL CO., C		.,	,			
				. b6 · b7c	·- :	dag.
ONTRACTOR	oc me		HPGIID	IPS REP		
CONTRACTOR STATES	,	DIAL IND			n	ate last Alibrated 9–10–81
ASURING	INSTRUMENT USE	D	CUNIN	OL NO.		RL L D B. C. S. C.
	READINGS AS	FOUND	CALIB	RATION MARK	ED (YES) NO
	REFERENCE DIMENSION	REFERENCE TOLERANCE	MEASURED DIMENSION	ACCEPT	REJECT	
CAM ANDRIG				vv		
EAR	.008	.005	.004	XX		
RIGHT TO	.003	,	.003	XX "		
GEAR	.003	.005				
IDLERK-		•	.004	XX		
SHAFT GEAR	.003	.005			••	
BLOWER						
DRIVE GEAR	.003	.005	.006	. XX	•	
UEAR	.000	.003	•			
			<u>'</u>	· · · · · · · · · · · · · · · · · · ·		
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UBJECT:	BLOWE	R"CLE	ARANCE FRO	NT S/N	12VA5	3217		
CONTRACTOR:	· BAY C	ITY M	ARINE					
SHIP: USS	DURHAM	LKA -	-114 CONTRA	ACT NO:_	всм	116-81	Spec	: NO: SD -688-81
ARTICLE NO:	583-41	-004	PARA I	NO: 3.7.	10.49	IDR NO:	PH-)	NO: SD -688-81
•			OR SKETCH RE					
		1410,	MFG. WEAR L	•				-
								4
	Г					ь6 ь7с		

CONTRACTOR	-			 	SUPSH	IPS REP	3	DATE LAST 9-10-8 CALIBRATED
MEASURING 1	INSTRUMEN		DIAL IND FEELER GAUGE		CONTR	ol No.	·	_ CALIBRATED
י ש פ	DINGS AS	•	1			CALIBRATION	MARKED (res) no
PART OR	REFEREN	ICE	REFERENCE TOLERANCE	MEASU DIMÉN		ACCEPT	REJECT	
ROTOR TRAILING EDGE		002		.005		XX		
ROTOR LEADING EDGE	MIN. MAX.	1	.006	.010			XX	
ROTOR TO FRONT END PLATE	MIN.		.002	.008	1	XX	• •	
ROTOR TO REAR END PLATE	MIN. MAX.		.002	.014			xx	
ROTOR TO HOUSING INLET SID	MIN. E MAX.		.002	.014			XX	•
ROTOR TO HOUSING OUTLET	MIN. MAX.		.002	.007		xx*•		
TIMING GEAR BACKLASH	MIN. MAX.		.0035	.002		xx		

A 410 6

SMBJECT:	BLOWER CLE	ARANCE	(REAR_)	12VA532	17		
	BAY CITY MA	RINE		1			
USS	DURHAM LKA-11	4 CONTRA	ACT NO:	всм	116-81	SPEC	SD-688-81
ARTICLE NO:	583-41-004		3.7. NO:	10.49	IDR NO:	PH N	0:
MAYSHIP AND)/OR PLAN AND/	OR SKETCH RE	PBRENCE WEAR L	MITS			
1244 442-42-4244					·		
CONTRACTOR	QC INSP			SUPSHI	PS REP.		
MEASURING 1	INSTRUMENT OSE	D DIAL IND-		· CONTRO	L NO. 191-3	•	DATE LAST CALIBRATED 9-10-81
				•			
	EADINGS AS FOUN				ALIBRATION	MARKED ()	(ÉS) NO
PART OR PC NO.	REFERENCE DIMENSION			RED	ACCEPT	REJECT	
ROTOR TRAILING EDGE	MIN. 002 MAX. 006	.004	.006	•	xx		
ROTOR LEADING EDGE	MIN. 016 MAX. 022	.006	.008			xx	
ROTOR TO FRONT END PLATE	MIN. 007	.002	.010			XX.	
ROTOR TO REAR END PLATE	MIN. 007 MAX. 009	.002	.015			XX	
ROTOR TO HOUSING INLET SII	MIN. 017 DE MAX. 019	.002	.012			XX	•
ROTOR TO HOUSING OUTLET	MIN. 005 MAX. 007	.002	.006		xx ••		
GEAR BACKLASH	MIN. 0005 MAX. 004	.0035	.0015	,	xx		

FROM: BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050	Contract: 116-81 Date: 10-20-81 Vessel: LCM-8 Hull: 74CM6783
TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119 San Diego, California 92136 Attn: Code #	Spec. S/D
☐ Required Report(s)	Enclosure(s):
□ Schedule of Events □ Excess Material □ Supships S/) 4500/2 □ Drawing(s) □ Test Memo □ J.O. Exception(s) Completed □ □ □ □ Comments: REQUEST FORMAL HULL INSPEC	REQUEST HULL INSPECTION PER PARA 3.16 OF ITE XXX; 583-41-004 PT III ***TION 0900, 10-22-81
	CONTRACTS OCT 20 10 09 AM 81
,	HE ACCEPTABLE

BAY CITY MARINE, INC. Signatur

^{e:} 10-28-81

Supship Signatur

b6 b7C

LETTER OF	TRANSMITTAL No. LOT 17
FROM: BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050	Contract: 116-81 Date: 10-29-81 Vessel: LCM-8 Hull: 6765 & 6783
TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119 San Diego, California 92136	Item: <u>583-41-003 & 004</u> Mod Spec. S/D <u>688-81</u>
Attn: Code # <u>1509-1</u>	Reference: STD ITEM 009-17 (FY-88, 12 SEPT 80)
Required Report(s) Schedule of Events Excess Material Supships S/) 4500/2 Drawing(s) Test Memo J.O. Exception(s) Completed	Enclosure(s): 1. SURGE TEST PER PARA X 3.3 of PT VI ITEMS 583-41-003 & 4
RECEIVED AND NOTEL	DET 29 9 52 AM 981
Signatur ate: 10-29-81	Supships Signature Date: 10 - 30-8

LETTER OF	TRANSMITTAL No. LOT 19
FROM: BAY CITY MARINE, INC. 1411 Harding Avenue National City, CA 92050 (714) 474-8121	Contract: 116-01 Date: 11-5-61 Vessel: 008HAM Hull: #6765
TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119	Item: 583-41-003 Mod Mod
San Diego, California 92136 Attn: Code # 1509-10 MEDRANO	Reference: PARA 3.18 of 009-17, FY82, 12 Sept 80
Required Report(s)	Enclosure(s):
☐ Schedule of Events ☐ Excess Material	SEE THE ENCLOSURES FOR THE BALANCE REPORTS ON THE TWO (2) ALTERNATORS ROTOR
☐ Supships S/D 4500/2	
☐ Drawing(s)	
☐ Test Memo	
☐ J.O. Exception(s) Completed	
Comments:	
REPORT ONLY	
BAY CITY MARINE, INC.	Supships
Signature: Date:	Signature: Date:

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1. 1. A.	•				•	÷		
• 10				REVISIONS			and the second	
LTR.			D	ESCRIPTION	4		DATE APPR	OVED
A	Removed DSR N	Number.				etc.	7/13/71	Ь
В	Replaced Shee	et Numbe	r 1 &	2. Remo	ved SUPS	SHIP REP	11/7/73	b
C	From Sheet 3	77					0 /27 /7/1	-
D	Revised Enclo			· · ·	mal Inci	mations	9/17/74 11/22/78	H
	Revised Enclo			eu delle	THT THE	Juc CIOIIS,	11/22/19	
			· /	 				
							•	
1.				AUTHORIT	Υ			
DSR:		PM NO:			OL	B ORDER NO.:		
PLANNE	R:	CODE:			TY	PE DESK CODE:		
							•	•
2.		CONT	RACTO	RS TEST C	ERTIFICA	TION		
IN (ALL F TEST DIF	CCEPTANCE TESTS I RESULTS, DATA, DE RECTOR SIGNATURE SPECTOR SIGNATURI	FICIENCIE		DATE	CTION TAI		DED IN THE TEST REJECTED	MEMO)
	RT A17	=		PAIE	10 -50	DANCEL IED	1 0 FILLIED	لـــــا
3.		· 190		11150 4115	DICTRIBLE	TION		
<u>J.</u>		DE2	IGN: KE	VIEW AND	DIZIKIRO	TION		
SUBMITT	ED BY TRANSMITTA	L NO			CONT	RACT NO.	SPEC. NO	
ITEM NO) PM N	10.		PLANNER				j
	TION: ACCEPTED	 1				7	EJECTED -	
_			EFIED	•		INSPECTION	r	1
	NECESSARY: PLAN			DESIGN		INSPECTION	JN L	
DESIGN	MEMO: NECESSARY	لـــا		UNNECE		J		
TEST ME	MO REVIEWED BY: .				ODE	DAT	E	
DISTRIB	UTION: SHIP 🔲 22	25 🗀 226	DESIG	SN CODE	TYP	E DESK	OTHER	
	· · · · · · · · · · · · · · · · · · ·		· · · · · · · · · · · · · · · · · · ·					
			DESIGN	TEST ME	MURANDIIA	A		
					· · · · · · · · · · · · · · · · · · ·		ND REPAIR, USN	
	EXAMINED					SAN DIEGO, CALI		
							ime of test)	
OFFICIAL	SIGNATURE	CODE DATE		•				1
····	<i>/</i>	- 1,	U.S.S	401	/ 0		_ (74c/16)	65)
PREPARED		/18/		T A T A 37/7/T?	TO 43775 T	TTDD AMTON DI		
BY /		261 /19				TBRATION RE OVERHAUL OF		
SECTION		1//		NAVAL MA			ROTATING	
HEAD		261 118/79				•		-
		204		•				l
BRANCH							•	1
HEAD		260 14						
TECH. M	ANUAL #				•			
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	T amm = (= /= \	A		1 []]				,, ,,
MI	L-STD-167 (1)	SHIPS	B A	[] &	VIB	REQR	<u> </u>	HY
TM ISSUE	DATE: 18 JAN	7 9	si zo	26	รา	090	1056	REV.
TIMP	#111m an Ann 400 100		II.				1, 200	<u> </u>
เหม-รูปค	SHIP-SD-9000/30 (RE	V. 5/74)	SCALE	NC	SCALE		ľ	

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SHIP: 24 C/16765	- LCM-8	DATE:	10-30	-8/
	BALANCING WORKSHEET	·		-
EQUIPMENT: PORT	AIT. ROTOR			
FROM: BBY CI	74			
TO: SUPERVISOR OF SHI	PBUILDING, CONVERSION 8	c REPAIR,	USN, SAN D	DIEGO, CA.
ART. NO.:	PARAGRAPH: 3.18 of oog.	CONTRACT	NO.: //6	-8/
SPECIFICATION NO.: 6	88-8/ MOD. NO) .:		<u>.</u>
**************************************	DESCRIPTIONS AND SPECE			· · · · · · · · · · · · · · · · · · ·
WORK ORDER NO.: NOO	2/9 PO. NO.: 240	3 ITEM	:5834	1-003
	A. DATA SUMMARY	•		
1. Weight of Rotating	Mass		14	POUNDS
2. Dimensions of Rotating Mass	LENGTH	· · · · · · · · · · · · · · · · · · ·	8	INCHES
	DIAMETER		, ' /	INCHES
3. Speed of Rotating Mass	SHOP BALANCING		400	RPM
	IN PLACE BALANCING		1800	RPM
4. Residual Unbalance	PRIOR TO BALANCING	PLANE A:		OZ/INCHES
		PLANE B:		OZ/INCHES
, •	AFTER SHOP BALANCING			OZ/INCHES
	Allowed per MIL-STD-1	PLANE B:		OZ/INCHES
	(Ships) Para. 5.2.2.2		.03	OZ/INCHES
B. Instrumentation &	Type of Balancing Mach	ine Used:	•	
1. Shop Balancing	Date Last Cal	ibration	Se	nsitivity
	6-10.			· 004 k
Certified By:			<u> 1 - 30 -</u> Dat	8/ e
Witnessed By:	tnessed By:			
WI WILLOW DOWN Dy .	<u></u>		Dat	é
Witnessed By:	Supship Rep.		Dat	e
тм 01056	·: ENCLOSURE (1)	•	p	

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Planta de la constantina della					
SHIP: 74 C/7.6765 LC/9-8 DATE: 10-30-81					
``	•		G WORKSHEET		-
EQUIPMENT: PORT	AL	17.	ROTO	o R	
Correction Pla	C. ane "A	Shop "	Balancing Dat	Correction	Plane "B"
00210001011 112	aric A			0	
			·	270	Driver End
Driven End 270	90	·	Inches	180	
180			4		ord Distance ween Planes
DESCRIPTION		ST	ATIC BALANCE	DYNA	MIC BALANCE
Original Unbalance	.00	06	oz/inches	.718	OZ/INCHES
eight (Added-Remove)	NI	B	OZ PLANE A	./26	OZ PLANE A
•	M	9	OZ PLANE B	.176	OZ PLANE B
Radius of Weight	NI	9	IN PLANE A	2	IN PLANE A
(Added-Remove)	Nh	4	IN PLANE B	2	IN PLANE B
Angle of Weight	M	9	DEG PLANE A	90	DEG PLANE A
(Added-Remove)	Nh	2	DEG PLANE B	270	DEG PLANE B
Final Unbalance	.00	36	OZ/INCHES	.006	OZ IN PLANE A
				.006	OZ IN PLANE B
D.	Fina	l Ba	lance Machine	Settings	
Sensitivity (Lo, Hi, X-	·Hi)		Hj	141	•
Dash Pot (1 through 5)			/		
Unbalance Meter .04			.09		
NOTE: Reference mark sin order to ider					
			17	1.00/	ь6 ь7с
тм <u>01056</u>		Enc	losure (1)		

8	
INED HERE- TEST MEMO) ECTED ECTED	Ь6 Ь7С
NO	
R, USN 136 test) 1/67637	
NG	

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LTR.	,		·	DESCRI	PTION			, , , , , , , , , , , , , , , , , , , 	T	DATE	APPR	OYED
_A	Removed DSR 1	Number.				& E.	etc.		7	/13/7	1	
B	Replaced Shee	et Numbe	rl&	2,	Remove	d SUP	SHIP	REP	1)	./7/73		
C	From Sheet 3	, , , , , , , , , , , , , , , , , , , ,	· · · · · · · · · · · · · · · · · · ·							/3 er /er li	11	Н
D	Revised Enclo					J Tma	+	-t on o		17/74		H
	Revised Cover			sea (gener	u ins	truci	tions,	╌┼	./22/7	9	
	Nevibed Inter	saute 11	:/	·······		•						
•		······································								· · · · · · · · · · · · · · · · · · · 		
1.		· · · · · · · · · · · · · · · · · · ·		AUTHORITY								
DSR:		PM NO:)(OB ORD	ER NO.:				
PLANNE	R:	CODE:				T	YPE DE	SK CODE	:			
		•								·		•
2.		CONT	TRACTO	ORS TE	EST CEI	RTIFICA	TION					
FINAL AC	CCEPTANCE TESTS	HAVE BEEN	CONDI	CTED	IN ACC	RDANC	E WITH	PROCED	URES	CONTA	INED H	IERE-
IN (ALL F	RESULTS, DATA, DE	FICIENCIE	S & C0	RRECT	TIVE AC	TION TA	KEN A	RE RECO	RDEC	IN THE	TEST	MEMO)
TEST DIE	RECTOR SIGNATURE	_			MEL			CCEPTE	<u> </u>	DEII	ECTED	
	PECTOR SIGNATURE							CCEPTE		_/		
		<u> </u>			PATE	0-50	-811	CCEPTE	0 0	KFJ	CTED	<u> </u>
	5780	914/1	101	04				~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~				
3.		DES	IGN: R	EVIEW	AND D	ISTRIBL	HOITI					
SUBMITT	ED BY TRANSMITTA	L NO.				CON	TRACT	NO.		SPEC. N	10	
!	• PM N											
I	ر ــــ						 1	•			7	
L .	TION: ACCEPTED		CEPTED	•		TONS L				CTED	1	l
	NECESSARY: PLAN				SIGN L	니 尸	- ~₁	INSPECT	ION	لــا		ł
DESIGN	MEMO: NECESSARY		• •	UN	NECESS	ARY /						.
TEST ME	MEMO REVIEWED BY: CODE DATE											
DISTRIB	RIBUTION: SHIP 225 226 DESIGN CODE TYPE DESK OTHER											
										711161		
·							-,					 }
~~~			DESIG	N TES	T WENC	RANDU	M					
	· EXAMINED	٠.						VERSION EGO, CAL				
			SUBJE	CT: (	Fill:	ln shi	p nar	me at	time	e of t	est)	
OFFICIAL	SIGNATURE	CODE DATE			17	_ 0		•		174-		اد
		1/	0.5.5.			٥.	· · · · · · · · · · · · · · · · · · ·			(74c	176',	1637
PREPAR BY		/18/	١.,	RΔT.Δ	NCTNG	AND I	TRRA	TION R	गठा	TREME	פידע	1
D)		261 /19						HAUL O	-			1
SECTIO		1/101				HINER						
HEAD		26] /18/79			•		-					
		17	İ									
BRANC HEAD		260 1/18/74	1									
		260 14						-				
TECH. M	ANUAL #		1		·							
			<b></b>	<del></del>		<del>, , , , , , , , , , , , , , , , , , , </del>	<del></del>	<del>,</del>	· · · · · ·	<del></del>	<del></del>	<del></del>
1/7	T 0000 160 /=\	C777 55	.	_	.		"   "		ارا.			,, ,,
MI.	L-STD-167 (1)	SHIPS	BA	니	& V	I B	RE	Q R	0	r M	A C	
TM ISSUE	DATE: 18 JAN	<b>7</b> 9	size		660		1,	000		. 300	_ i	REV.
			A	<u> </u>	261		<u></u>	090		105	00	D
TIND-SUP	SHIP-SD-9000/30 (RE	V. 5/74)	SCALE		NO	SCALE			1	•		

SHIP: 6011-8	24e/76765 DATE:	10-3	0-81			
	BALANCING WORKSHEET	-				
EQUIPMENT: 5780	ALT. ROTOR					
FROM: BAY e	FROM: BAY eity					
TO: SUPERVISOR OF SHIPBUILDING, CONVERSION & REPAIR, USN, SAN DIEGO, CA.						
ART. NO.:	PARAGRAPH: 3. 18 Josq. GONTRACT	NO.: // 6	6-8/			
,	8-8/ MOD. NO.:					
WORK	DESCRIPTIONS AND SPECIFICATIONS	<u> </u>				
WORK ORDER NO.: NOO	19 PO. NO.: 2403 ITEM	1: 583-4	41.003			
	A. DATA SUMMARY					
1. Weight of Rotating	Mass .	14	POUNDS.			
2. Dimensions of	LENGTH	8	INCHES			
Rotating Mass	DIAMETER	2	INCHES			
3. Speed of	SHOP BALANCING	400	RPM			
Rotating Mass	IN PLACE BALANCING	1800	RPM			
4. Residual Unbalance	PRIOR TO BALANCING PLANE A:	,435	oz/inches			
ombatance.	PLANE B:	.012	OZ/INCHES			
•	AFTER SHOP BALANCING PLANE A:	.0/2	OZ/INCHES			
	PLANE B:	.012	OZ/INCHES			
	Allowed per MIL-STD-167-1 (Ships) Para. 5.2.2.2	.03	oz/inches			
B. Instrumentation &	Type of Balancing Machine Used:					
,	, ,	b6 b7C				
1. Shop Balancing	Date Last Calibration	Se	nsitivity			
	6-10-8		.004			
Certified By:	·	0-30-0 Dat	81/			
Trackers and a more		70 C	75 C			
Witnessed By:		Dat	<del>é</del>			
Witnessed By:						
S	upship Rep.	Dat	e			
		k	1			
TM <u>01056</u>	ENCLOSURE (1)					

SHTP: 60/1-8	74C16765 DATE: 10-30-81					
, , , , , , , , , , , , , , , , , , ,	٠.	_	G WORKSHEET	•	-	
EQUIPMENT: 578D	F	27	. Roi	OR		
Correction Pla	C.	Shop	Balancing Dat		Plane "B"	
Driven End				270	Driver End	
270	90		Inches	180 N		
180			MIA		ord Distance ween Planes	
DESCRIPTION		ST	ATIC BALANCE	DYNAMIC BALANCE		
Original Unbalance	. 008		oz/inches	.439	OZ/INCHES	
eight (Added-Remove)	M	p.	OZ PLANE A	.212	OZ PLANE A	
•	111.	A	OZ PLANE B	NIA	OZ PLANE B	
Radius of Weight	NI	9	IN PLANE A	. 2	IN PLANE A	
(Added-Remove)	NIA		IN PLANE B	NA	IN PLANE B	
Angle of Weight	11/	14	DEG PLANE A	80	DEG PLANE A	
(Added-Remove)	14	13	DEG PLANE B	NIA	DEG PLANE B	
Final Unbalance	100	28	oz/inches	.008	OZ IN PLANE A	
				.008	OZ IN PLANE B	
D.	Fina	l Ba	lance Machine			
Sensitivity (Lo, Hi, X-	Hi)		Hi	HI		
Dash Pot (1 through 5)						
Unbalance Meter			.05	.07		
NOTE: Reference mark sin order to iden	hall tify	be p O de	laced on eithe gree position	er end of rota	ating assembly	
				TiR.	. 0008	
TM 01056 Enclosure (1)						

FROM:  BAY CITY MARINE, INC.  1411 Harding Avenue  National City, CA 92050  (714) 474-8121	Contract: 116-81 Date: 11-6-81  Vessel: DURKAN Hull: #6783
TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119 San Diego, California 92136  Attn: Code #	Spec. S/D
■ Required Report(s)	Enclosure(s):
☐ Schedule of Events ☐ Excess Material	SEE THE ENGLOSURES FOR THE BRANCE REPORTS ON THE TWO (2) ALTERNATOR ROTORS
☐ Supships S/D 4500/2 ☐ Drawing(s)	
☐ Test Memo ☐ J.O. Exception(s) Completed ☐	
Comments:	· · · · · · · · · · · · · · · · · · ·
BAY CITY MARINE, INC.	Supships
Signature:Date:Date	Signature:Date:

			<del></del>	REVI	SIONS		***************************************	
LTR.					IPTION			DATE APPROVED
A B	Removed DSR Nu	mber,	J.O.	Numb	er, P	& E,	etc.	7/13/71
. <u>B</u>	Replaced Sheet From Sheet 3	Numbe	r 1 8		Remove	d_SUP	SHIP REP	<del> 11/7/73  </del>
С	Revised Enclos	sure (1			•	<del></del>		9/17/74
D	Revised Cover	Sheet,	Revi	sed	Genera	l Ins	tructions,	11/22/78
	Revised Enclos	sure (1	.)					<u> </u>
,			<del></del>	<del></del>				
1.				AUTI	HORITY			
DSR:		Рм но:		,		JO	B ORDER NO.:	
PLANNE	R: (	CODE:				TY	PE DESK CODE:	
2.		CONT	TO A CT	206 76	TOT CE	TIFICA	TION	•
CONTRACTORS 1231 CERTIFICATION								
FINAL ACCEPTANCE TESTS HAVE BEEN CONDUCTED IN ACCORDANCE WITH PROCEDURES CONTAINED HERE-IN (ALL RESULTS, DATA, DEFICIENCIES & CORRECTIVE ACTION TAKEN ARE RECORDED IN THE TEST MEMO								
	ECTOR SIGNATURE:				PATE	0-30	ACCEPTED	REJECTED
TEST INS	PECTOR SIGNATURE:				PATE	1 -30-	ACCEPTED	REJECTED
	RT AL	1//	RO				,	•
3.		DES	IGN: R	EVIEW	AND D	STRIBU	TION	
SUBMITT	ED BY TRANSMITTAL	NO	•			CONT	RACT NO.	SPEC. NO
	РМ НО							
EVALUA	TION: ACCEPTED	ACC	EPTED	WITH	EXCEPT	IONS [	RI	EJECTED -
l .	NECESSARY: PLANNI	MG L		DE	sign L	┙ ٫﹏	INSPECTI	ן אכ
DESIGN A	MEMO: NECESSARY L		•	UN	NECESS.	ARY L	J ,	, - , ,
TEST ME	MO REVIEWED BY:	·			cor	DE	DAT	E
DISTRIBL	JTION: SHIP 225	226	DES	IGN CO	DE	ТҮР	E DESK	OTHER
· · · · · · · · · · · · · · · · · · ·			····	•				
				······································		RANDUA	<del></del>	
	EXAMINED	· .	ELEVE	NTH N	AVAL DI	STRICT S	SAN DIEGO, CALI	
OFFICIAL	SIGNATURE CO	DE DATE	,	•		•	o name.at t	ime of test)
PREPARED		1/2	u.5.5.		<u> </u>			(740/16783)
BY	_	118						QUIREMENTS
الم	1 2	61 /19		FOR	REPAI	R AND	OVERHAUL OF	
SECTION HEAD		261 118/79		NAVA	ب MAC	HINERY	•	
BRANCH	<del>                                   </del>			•	•			,
HEAD		1/18/174						
TECH. M		·		,	•			
MII	L-STD-167 (1) S	SHIPS	вА	L	& V	IB	R E Q R	OT MACH Y
TM ISSUE	DATE: 18 JAN 7	79	si zo A		261	,	090	REV. 1056 D
TIND-SUPS	HIP-SD-9000/30 (REV.	5/74)	SCALE		NO S	CALE		SHEET 1 OF 5

b6 b7С

	94C/96783 DATE:	10-3	0-81
, .	BALANCING WORKSHEET		-
EQUIPMENT: PORT	ALT. ROTOR		
	, "	•	•
FROM: BIJ C		TION CAN	DIEGO CA
	PARTICIPATION & REPAIR,		
ART. NO.:	PARAGRAPH: 3/8 of oog-12 CONTRACT	: NO.: //	6-8/
	88-8/ MOD. NO.: C. DESCRIPTIONS AND SPECIFICATIONS	<u> </u>	
	2/9 PO. NO.: 2403 ITEM		1-004
	A. DATA SUMMARY	14	DOLLNIDG .
1. Weight of Rotating		8.	POUNDS
2. Dimensions of Rotating Mass	LENGTH	7	INCHES
	DIAMETER		INCHES
<ol><li>Speed of Rotating Mass</li></ol>	SHOP BALANCING	400	RPM
	IN PLACE BALANCING	1800	RPM
4. Residual Unbalance	PRIOR TO BALANCING PLANE A:	. 285	OZ/INCHE
	PLANE B:	. 785	OZ/INCHE
	AFTER SHOP BALANCING PLANE A:	.009	OZ/INCHE
	PLANE B: Allowed per MIL-STD-167-1	-009	OZ/INCHE
	(Ships) Para. 5.2.2.2	.03	OZ/INCHE
B. Instrumentation &	Type of Balancing Machine Used:		•
,			-
1. Shop Balancing	Date Last Calibration	b6	ensitivity
	6-10-81	ь7C	-004
Certified By:		3-30-Da	ze
Witnessed By:	· //>	30-8	· ·
		Da	će
Witnessed By:	Supship Rep.	Da	te .
,	pubpitth tioh.		gap a wages
		-,	

Since Land		*	•	
SHIP: LC/4-8	7404	6783	DATE: 10	-30-81
•		G WORKSHEET		
EQUIPMENT: PORT	92 T.	ROTOR		
		Balancing Dat		
Correction Pla	ne "A"		Correction	Plane "B"
0		-	270	Driver End
Driven End 270	90	Inches	180	•
180		4		rd Distance een Planes
DESCRIPTION	sī	ATIC BALANCE	DYNA	MIC BALANCE
Original Unbalance	.429	OZ/INCHES	1.14	OZ/INCHES
eight (Added-Remove)	.106	OZ PLANE A	. 282	OZ PLANE A
	.106	OZ PLANE B	. 282	OZ PLANE B
Radius of Weight	2	IN PLANE A	2	IN PLANE A
(Added-Remove)	. 2	IN PLANE B	2.	IN PLANE B
Angle of Weight	0	DEG PLANE A	35	DEG PLANE A
(Added-Remove)	0	DEG PLANE B	215	DEG PLANE B
Final Unbalance	.006	OZ/INCHES	.006	OZ IN PLANE A
·			.006	OZ IN PLANE B
D.	Final Ba	alance Machine	Settings	
Sensitivity (Lo, Hi, X-	Hi)	<i>H</i> ./	7.	<i>!'</i>
Dash Pot (1 through 5)			1	
Unbalance Meter		104	. 00	<u> </u>
NOTE: Reference mark s in order to iden	hall be p	placed on either	er end of rota	
	·		T12-0	00 4-
тм 01056	·_F···c	closure (1)	P	AGE 5 of 5

		······································	··	REVISIONS				
LTR.	T			DESCRIPTION		DATE AP	PROVED	
_A-	Removed DSR	Number.		Number, P & E;	etc	7/13/71	INOTED	
В	Replaced She	et Numbe	r 1 &	2, Removed SUP	SHIP REP	11/7/73		
	From Sheet	5						
C	Revised Encl			· .		9/17/74		
<u> </u>	Revised Cove	r Sheet	Revi	sed General Ins	tructions,	11/22/78		
· · ·	Revised Encl	cosure (1	<u>-)</u>					
•		**************************************	<del></del>					
1.		<del></del>		AUTHORITY		**		
DSR:		PM NO:	<del></del>		OB ORDER NO.:			
PLANNE	R:	CODE:			YPE DESK CODE:	<del></del>	<del></del>	
					TTE DESK COPE.	·····		
2.		CON.	TRACTO	DRS TEST CERTIFICA	TION		***************************************	
	CONTRACTORS TEST CERTIFICATION  FINAL ACCEPTANCE TESTS HAVE BEEN CONDUCTED IN ACCORDANCE WITH PROCEDURES CONTAINED HERE-							
IN (ALL	RESULTS DATA D	HAVE BEEN	S & CO	RRECTIVE ACTION TA	E WITH PROCEDUR	ES CONTAINEI FO IN THE TE	HERE-	
			<u> </u>	AKECTIVE ACTION TA	NEW AND RECORD	<del></del>		
	RECTOR SIGNATURE			DATE 10-30	-8/ ACCEPTED	REJECT	ED	
TEST INS	PECTOR SIGNATUR	E:	· ·	DATE 10 -30	87 ACCEPTED	REJECT	ED	
_57	SD BL	- 1 A96	TOX	3				
3.				EVIEW AND DISTRIBL	JTION			
SUDMET	CD DV TD MAN			<del></del>				
SUDMII I	ED BI IKANSMIII	AL NO	<del></del>	CON	TRACT NO.	_ SPEC. NO		
1				PLANNER				
EVALUA	TION: ACCEPTED	ACC	CEPTED	WITH EXCEPTIONS	_	ECTED		
	NECESSARY: PLAN			DESIGN	INSPECTION	()		
_	MEMO: NECESSARY			UNNECESSARY				
1		•						
1	MO REVIEWED BY:			CODE			<del></del>	
DISTRIB	UTION: SHIP 1	225 226	DESI	GN CODETY	PE DESK	OTHER		
							•	
			DESIG	TEST MEMORANDU	M	•	•	
, ,	· EVALUERA		SUPER	ISOR OF SHIPBUILDIN	G CONVERSION AN	D REPAIR. US	1	
	. EXAMINED	*	ELEVE	NTH NAVAL DISTRICT	SAN DIEGO, CALIF	ORNIA 92136		
OFFICIAL	SIGNATURE	CODE DATE	SUBJE	T: (Fill in shi	p name at tir	ne of test	;)	
[	,		U.S.S.	LC14-8		(740190	(583)	
PREPARED		1/10		-		•	•	
BY		063/19/		BALANCING AND Y	VIBRATION REQ	UIREMENTS		
1		261 /17		FOR REPAIR AND		ROTATING		
SECTION HEAD		261 1879		NAVAL MACHINERY	₹•			
HEAD		261 19		•				
BRANCH		1/101			•			
HEAD		260 1/8/74						
<del></del>		200 1	<b>'</b>	•				
TECH. M	ANUAL #							
		<del></del>						
			: 1		1 1 1 1 1		1 1	
MI	L-STD-167 41)	SHTPS	BIAL	LI & VIIB	RED TRIO	T MAIC	HY	
	L-STD-167 (1)		<del> </del>	L & VIB	REQRO	T MAC		
	L-STD-167 (1) DATE: 18 JAN		B A	261	REQ RO	T MAC 1056	REV.	

SHIP: LCM-8		4619678	3	DATE:	10-30	-81		
BALANCING WORKSHEET -								
EQUIPMENT: STA	BD	ALT. ROT	OR					
FROM: BAY CITY								
ART. NO.:	ART. NO.: PARAGRAPH: 3.18 dang., CONTRACT NO.: 1/6-8/							
SPECIFICATION NO		_						
WORK DESCRIPTIONS AND SPECIFICATIONS								
WORK ORDER NO.: No. 2/9 PO. NO.: 2403 ITEM: 583-41-004								
		A. DATA	SUMMARY					
1. Weight of Ro	tating	Mass			14	POUNDS		
2. Dimensions of		LENGTH		*	8	INCHES		
Rotating Mas		DIAMETER	•		2	INCHES .		
3. Speed of		SHOP BALANCING		, , ,	400.	RPM		
Rotating Mas		IN PLACE BALANC	CING		1800	RPM		
4. Residual		PRIOR TO BALANC	CING	PLANE A:	.504	OZ/INCHES		
Unbalance				PLANE B:	.5-64	OZ/INCHES		
		AFTER SHOP BAL	ANCING	PLANE A:	.0105	OZ/INCHES		
·		A 7 7 2 2	r comes 1	PLANE B:	0105	OZ/INCHES		
		Allowed per MI (Ships) Para.		)(~T	. 20.03	oz/inches		
B. Instrumentat	cion & T	ype of Balanci	ng Mach	ine Used:				
1. Shop Balanci	lng	Date L	ast Cal	ibration		nsitivity		
			6-1	0-81	b7C	.004		
Certified By:					0-30-	8/		
Witnessed Bre				1.0	Dat	~ ~		
Witnessed By:				(0	Dat	é		
Witnessed By:					<u> </u>	Δ		
	su	pship Rep.			Dat	· C		
			. •	•	· *	- 1		
TM 01056	<b></b>	ENCLOS	<u>E (1)</u>					

SHIP: L < 17 - 8 24 < 17 < 283 DATE: 10-30-81 BALANCING WORKSHEET ROTOR EQUIPMENT: BLT Shop Balancing Data Correction Plane "B" Correction Plane "A" Driver End 270 Driven End 270 90 180 Inches *Record Distance Between Planes STATIC BALANCE DYNAMIC BALANCE DESCRIPTION OZ/INCHES .014 ,995 OZ/INCHES Original Unbalance .247 OZ PLANE A eight (Added-Remove) OZ PLANE A N//B OZ PLANE B .247 OZ PLANE B IN PLANE A 2 IN PLANE A NIA Radius of Weight (Added-Remove) IN PLANE B IN PLANE B NIB DEG PLANE A 50 DEG PLANE A Angle of Weight (Added-Remove) DEG PLANE B DEG PLANE B 50 11/19 OZ IN PLANE A .007 OZ/INCHES Final Unbalance .007 OZ IN PLANE B .007 Final Balance Machine Settings D. Sensitivity (Lo, Hi, X-Hi) Dash Pot (1 through 5) Unbalance Meter Reference mark shall be placed on either end of rotating assembly in order to identify 0 degree position. TM 01056___

Enclosure (1.)

A		1	
MCS 420-1848	MARINE	E CHEMIST, CERTIFICATE	
T2U-1848	· *	SERIAL NO. A 04537	ī
·	BCM	BCM YARD 6 57 Specific Location of Ve	b6 -b70
Survey Requested by CM - 8# 765	Vessel Owner of Agent  LCM-8	BCM WAND 6 55	
Vessel	Type of Vessel	Specific Location of Ve	essel
DIESEL Last Three (3) Cargoes	Vij FLET. Test Method	. 1754 Time Survey Compl	leted
CARGO DECK VONDS	No. 1. 2, 3; 4,	5,6,7	
ENGINE Room BILO	CE .		
LATARETTE BILGE			
UNSHIPPED FUEL OIL 7	ANKS (2)		<del></del> -
SAFE FOR WORK	KOCS		
SAFE FOR HOTH	ORH (K) (KX) EXCE	PT ON ADJACENT	
TANKS, SPACES AND V	DID STRUCTURES	NOT NOW	*****
corphies.			
- (A) Note: O REINSFE	T JUST PRIOR	TO ANY HOT WORK	
	FRE WATCH with	cor 'Ann	-
BAEH	, Le		
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THE PORT AND STBU S	Cheso MENE	PRION THAN.	
BLODER PLUGS AND F	Zund BAT a F	SAC MARIA TALL	<del></del>
Beaces VENTICATION			
Host Work	11954 375505	e con the G Fre G	
		*	
			<del></del>
In the event of any physical or atmo	spheric changes adversely affecting	g the gas free condition of the	W.
QUALIFICATIONS: Transfer of ballast or manipulation	of valves or closure equipment tending t	o alter conditions in pipe lines, tagis or compartments	
subject to gas accumulation, unless specifically approve affected. All lines, vents, heating coils, valves, and designated.	similarly enclosed appurtenances shall be	e considered "not safe" unless otherwise و considered عبد الله	
		the atmosphere is at least 19.5 percent by volume; and that, (b)	
conditions while maintained as directed on the Marine Che  NOT SAFE FOR WORKERS. Means that in the compartment	emist's Certificate.	apable of producing toxic materials under existing atmospheric	
SAFE FOR HOT WORK: Means that in the compartment so	o designated: (a) oxygen content of the atmosp	where is at least 19.5 percent by volume, with the exception of materials in the atmosphere is below 10 percent of the lower	
flammable limit; and that, (c) the residues are not capable o presence of fire, and while maintained as directed on the Ma	of producing a higher concentration than permit arine Chemist's Certificate: and further, that, (d	ted by (b) above under existing atmospheric conditions in the ) all adjacent spaces have been cleaned sufficiently to prevent n or fire room bilges, have been treated in accordance with the	
Marine Chemist's requirements.  NOT SAFE FOR HOT WORK: Means that in the compartn		•	
SAFE FOR REPAIR YARD ENTRY. Means that the compart remote sampling stations, and results indicate the atmosph	tments and spaces of the flammable cryogenic l	iquid carrier so designated: (a) have been tested by sampling at id less than 10 percent of the lower flammable limit, or (b) are	
		going list are in accordance with NFPA 306-1980 Control of Gas	
Hazards on Vessels and have found the condition of each to undersigned acknowledges receipt of this Certificate under Section 2	y 2-3 of NFPA 306-1980 This Certificate is base	ed on conditions existing a; ine time the inspection herein se	et .
and understands conditions and limitations under which it was issued."	forth was completed a instructions	and is issued subject to compliance with a" qualifications an	d
igned	· Sìgne	ed	
	Date IS CERTIFICATE IS VALID ONLY ON MAR		
6-80-MBF	CUST	OWER COPA	

#### MARINE CHEMIST CERTIFICATE

SERIAL NO.B 45341 **b**6

b7C

(13 C M 31 18-5) Requested by	Vessel Owner or Agent	Notaber 5, 198
14CM6765	Vessel Owner or Agent  LCM-8	Ben yard & Specific Location of Vess
/essel	Type of Vessel	Specific Location of Ves
ast Three (3) Cargoes	M D A. Test Method	1020 Time Survey Comple
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rut rails are free o	y combustible gase	sand liquids
where tested through	I plus holes	0
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	CTANDAD	D CAFETY DECICALATIONS : .
In the event of any physical or atmospheric to any of the above spaces, or if in any dou	: changes adversely affecting the STANDAR lbt, immediately stop all work and contact th	he undersigned Marine Chemist.
QUALIFICATIONS: Transfer of ballast or manipulation subject to gas accumulation, unless specifically approximately	vad in this Certificate, requires inspection and enc	dorsement or reissue of Certificate for the spaces so
affected. All lines, vents, heating colls, valves, and designated.	similarly enclosed appurtenances shall be co	nsidered "not safe" unless otherwise specifically
STANDARD SAFETY DESIGNATIONS (partial list, paraph		
SAFE FOR WORKERS: Means that in the compartment that, (b) toxic materials in the atmosphere are within per existing atmospheric conditions while maintained as directly atmospheric conditions.	rmissible concentrations; and that, (c) the residues ected on the Marine Chemist's Certificate.	s are not capable or producing toxic materials under
NOT SAFE FOR WORKERS: Means that in the compar SAFE FOR HOT WORK: Means that in the compartment	t so designated: (a) oxygen content of the atmosphe	ere is at least 19.5 percent by volume, with the excep-
tion of inerted spaces or where external hot work is to be p the lower flammable limit; and that, (c) the residues are conditions in the presence of fire, and while maintained ar- ing contained flammable or combustible materials have t tanks or lube oil tanks or engine room or fire room bilges	not capable of producing a higher concentration the second control of the Marine Chemist's Certificate; and people apped sufficiently to prevent the spread of f	an permitted by (b) above under existing atmospheric further, that, (d) all adjacent spaces containing or hav- ire, or are satisfactorily inerted, or, in the case of fuel
NOT SAFE FOR HOT WORK: Means that in the compa	artment so designated, the requirements of Safe fo	or Hot Work have not been met.
SAFE FOR REPAIR YARD ENTRY: Means that the comsampling at remote sampling stations, and results indicator (b) are inerted.		
CHEMIST'S ENDORSEMENT. This is to certify that I have of Gas Hazards on Vessels and have found the condition	e personally determined that all spaces in the forego n of each to be in accordance with its assigned de	oing list are in accordance with NFPA 306-1980 Control esignation.
The undersigned acknowledges receipt of this Certificate under Secti nd understands conditions and limitations under which it was issued	ion 2-3 of NFPA 306-1980 This Certificate is based on	conditions existing at the time the inspection herein set forth was object to compliance with all qualifications and instructions.
Signed	Signed_	550
	Date  HIS CERTIFICATE IS VALID ONLY ON MARINE	rigorne Cartificate No.

### MARINE CHEMIST CERTIFICATE SERIAL NO. B 45370 b7C Last Three (3) Cargoes sped ful tank In the event of any physical or atmospheric changes adversely affecting the STANDARD SAFETY DESIGNATIONS assigned to any of the above spaces, or if in any doubt, immediately stop all work and contact the undersigned Marine Chemist. QUALIFICATIONS: Transfer of ballast or manipulation of valves or closure equipment tending to alter conditions in pipe lines, tanks or compartments subject to gas accumulation, unless specifically approved in this Certificate, requires inspection and endorsement or reissue of Certificate for the spaces so affected. All lines, vents, heating coils, valves, and similarly enclosed appurtenances shall be considered "not safe" unless otherwise specifically designated. STANDARD SAFETY DESIGNATIONS (partial list, paraphrased from NFPA 306-1980, Subsections 1-6.1 through 1-6.4, and Subsection 5-3.2). SAFE FOR WORKERS: Means that in the compartment or space so designated: (a) the oxygen content of the atmosphere is at least 19.5 percent by volume; and that, (b) toxic materials in the atmosphere are within permissible concentrations; and that, (c) the residues are not capable of producing toxic materials under existing atmospheric conditions while maintained as directed on the Marine Chemist's Certificate. NOT SAFE FOR WORKERS: Means that in the compartment or space so designated, the requirements of Safe for Workers has not been met. SAFE FOR HOT WORKE: Means that in the compartment or space so designated, the requirements of oale for workers has not been met. SAFE FOR HOT WORK: Means that in the compartment so designated: (a) oxygen content of the atmosphere is at least 19.5 percent by volume, with the exception of inerted spaces or where external hot work is to be performed; and that, (b) the concentration of flammable materials in the atmosphere is below 10 percent of the lower flammable limit; and that, (c) the residues are not capable of producing a higher concentration than permitted by (b) above under existing atmospheric conditions in the presence of fire, and while maintained as directed on the Marine Chemist's Certificate; and further, that, (d) all adjacent spaces containing or having contained flammable or combustible materials have been cleaned sufficiently to prevent the spread of fire, or are satisfactorily inerted, or, in the case of fuel tanks or lube oil tanks or engine room or fire room bilges, have been treated in accordance with the Marine Chemist's requirements. NOT SAFE FOR HOT WORK: Means that in the compartment so designated, the requirements of Safe for Hot Work have not been met. SAFE FOR REPAIR YARD ENTRY: Means that the compartments and spaces of the flammable cryogenic liquid carrier so designated: (a) have been tested by sampling at remote sampling stations, and results indicate the atmosphere to be above 19.5 percent oxygen, and less than 10 percent of the lower flammable limit, or (b) are inerted. CHEMIST'S ENDORSEMENT. This is to certify that I have personally determined that all spaces in the foregoing list are in accordance with NFPA 306-1980 Control of Gas Hazards on Vessels and have found the condition of each to be in accordance with its assigned designation. This Certificate is based on conditions existing at the time the Inspection herein set forth was completed and is issued subject to compliance with all qualifications and instructions. undersigned acknowledges receipt of this Certificate under Section 2-3 of NFPA 306-1980 Signed Signed. NOTE: THIS CERTIFICATE IS VALID ONLY ON MARINE VESSELS

VESSEL POSTING

Printed in U.S.A

20M-5-81-MBF

SPEEDIPLY® PAT'D MCP® PAT'D MBF 28

## MARINE CHEMIST CERTIFICATE b6 SERIAL NO B /15371

			SERIAL NO.B 453/1
Requested by Requested by		US Massey Vessel Owner or Agent)	Detaber 11 1981
Requested by 14 CM 6783		A/ *	BCM your Chilla Dis
Vessel		Type of Vessel	
Last Three (3) Cargoes		MSUE Nosical Test Mathod	Z 8 2 0 Time Survey Compli
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- Heeplon box	inderies of	adjacent spaces	I structured not
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In the event of any physi	cal or atmospheric changes	adversely affecting the STANDARD	SAFETY DESIGNATIONS assigned
to any of the above space	es, or if in any doubt, immed	diately stop all work and contact the	undersigned Marine Chemist. conditions in pipe lines, tanks or compartments
subject to gas accumulation, unles	as specifically approved in this	Certificate, requires inspection and endo	rsement or reissue of Certificate for the spaces so idered "not safe" unless otherwise specifically
designated.			
SAFE FOR WORKERS: Means tha	t in the compartment or space s	n NFPA 306-1980, Subsections 1-6.1 througo o designated: (a) the oxygen content of the	atmosphere is at least 19.5 percent by volume; and
existing atmospheric conditions wh	ile maintained as directed on th	ne Marine Chemist's Certificate.	are not capable of producing toxic materials under
SAFE FOR HOT WORK: Means tha	at in the compartment so design	pace so designated, the requirements of S lated: (a) oxygen content of the atmosphere	e is at least 19.5 percent by volume, with the excep-
tion of inerted spaces or where exter the lower flammable limit; and that,	nal hot work is to be performed; a	and that, (b) the concentration of flammable of producing a higher concentration than	e materials in the atmosphere is below 10 percent of permitted by (b) above under existing atmospheric
ing contained flammable or combus	tible materials have been cleans	on the Marine Chemist's Certificate; and tu ed sufficiently to prevent the spread of fire on treated in accordance with the Marine (	rther, that, (d) all adjacent spaces containing or hav- , or are satisfactorily inerted, or, in the case of fuel Chemist's requirements
NOT SAFE FOR HOT WORK: Mea	ans that in the compartment so	designated, the requirements of Safe for	Hot Work have not been met.
sampling at remote sampling station	: Means that the compartments is, and results indicate the atmo	and spaces of the flammable cryogenic li sphere to be above 19.5 percent oxygen, an	quid carrier so designated: (a) have been tested by diess than 10 percent of the lower flammable limit,
or (b) are inerted.  CHEMIST'S ENDORSEMENT. This is	s to certify that I have personally	determined that all spaces in the foregoin	g list are in accordance with NFPA 306-1980 Control
of Gas Hazards on Vessels and have	e found the condition of each t	o be in accordance with its assigned desi	gnation. nditions existing at the time the inspection herein set forth wa
me undersigned acknowledges receipt of thi and understands conditions and limitations of	S Certificate under Section 2-3 of NF inder which it was issued."	completed and is issued subje	ct to compliance with all qualifications and instructions.
Signe	COC	10-//-8// Signed	550
	NOTE: THIS CERTI	FICATE IS VALID ONLY ON MARINE VI	Certificate No.
20M-5-81-MBF	VESSEL POSTING		Printed in U.S.A.

SPEEDIPLY® PAT'D MCPS PAT'D MBF 28

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5/N 0105-LF-804-2390

1. FROM:	• 2.		•3.	
Supship San Diego	<u> </u>	t 1981	1509-	1D #53
TO: Bay City Marine	DCM	116 01		
1411 Harding Ave. National City, Ca. 92050	BCM.	116-81		
national city, ca. 92050				
USS DURHAM LKA 114 (Small Boats	<u> </u>			
9. REFERENCE				
SPECIFICATION		PAGE	LINE	PARAGRAPH
Item 042-01		2	. '	3.5
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PROCEDURE NO.	<del></del>	PARAGRAPH	PAGE	
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10. THE FOLLOWING DEFICIENCY (188) REQUIRE (	CORRECTIVE ACTION	AS TOI	<del></del>	
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Page

. FROM: Supship San Diego	5 Oct	1981	1509	-1D #54
0: Bay City Marine	BCM 11	6_91	• 5.	
1411 Harding Ave.	+8.	.0-01	1.7.	
National City, Ca. 92050	Code We	lding		
CM 6 U.33 No SCONG 761				
.CM-6 Hull No. 56CM6761			· · · · · · · · · · · · · · · · · · ·	
SPECIFICATION		PAGE	LINE	PARAGRAPH
NAVSEA Standard Item 009-06		1 of 1	<u>. T</u>	3.1.1
DRAWING NO.		Lar.	· ·	
PROCEDURE NO.	, <del></del>	PARAGRAPH	PAGE	
OTHER (Specify)	<u> </u>			
Other (obesell)	•			
. THE FOLLOWING DEFICIENCY (188) REQUIRE COR	RECTIVE ACTION AS	TOI		
CORRECTION OF DEFECT	X CORREC	TION AS TO CAUSE		
	<del></del>			
ESCRIPTION OF DEFICIENCY(IES):				
. Paragraph 3.1.1 states: Plug	, blank, wrap	, cover, or mask	c equipme	ent, boats, an
penings to prevent entry of conta				stems, elec-
ronic equipment, valves, vents no	ot in use, and	other openings	•	
. During inspection of boat on	4 Oct 1981 it	was observed th	nat nume	rous nieces of
quipment (piping, vents, ect.) we	ere not protec	ted. One of th	e acces	s plates into
ort hull void was allowing blast	ing material t	o enter the voi	ld:	•
Contrastore records do not ad-	duage this am	\ <u></u>		
. Contractors records do not add	iress uns are	!a•		_
. This item was discussed with	<b>.</b>	M by		
				b7C
·				
		(Continue	on Back if	Nore Space Requir
· AUTHORIZED GOVT. REP. (Signature)	ODE	•12.		
	1509-1D	5 Oct 198	31	
37t ic vacuacted that a vanily in	dicating the d	corrective actio	on taken	or to be take
it is requested that a reply in		444		or to be care
It is requested that a reply ince provided to Supship Code 1509-	1D by 12 Oct	981.		Of to be cake
e provided to Supship Code 1509-  CONTRACTOR'S REPLY (Authorized Represented)	1D by 12 Oct	981.		Of to be care
e provided to Supship Code 1509-  - contractor's REPLY (Authorized Represented	1D by 12 Oct	981.		
e provided to Supship Code 1509-	1D by 12 Oct	981.	an kanan	Of to be take
e provided to Supship Code 1509- CONTRACTOR'S REPLY (Authorized Represented	10 by 12 Oct	981.		Of to be take
e provided to Supship Code 1509-	1 <u>D</u> by 12 Oct	981.		Of to be take
e provided to Supship Code 1509-	1 <u>D</u> by 12 Oct			Of CO DC Care
e provided to Supship Code 1509-  - CONTRACTOR'S REPLY (Authorized Represented	1 <u>D</u> by 12 Oct			OF CO DC CARC
e provided to Supship Code 1509- CONTRACTOR'S REPLY (Authorized Represented)	1 <u>D</u> by 12 Oct	(Signature)		(Date)
e provided to Supship Code 1509-  CONTRACTOR'S REPLY (Authorized Represente	ID by 12 Oct	(Signature)	Govt. Rep.	(Date)
e provided to Supship Code 1509-  CONTRACTOR'S REPLY (Authorized Represente	ID by 12 Oct	(Signature)	Govt. Rep.	(Date)
e provided to Supship Code 1509-  CONTRACTOR'S REPLY (Authorized Represente	ID by 12 Oct	(Signature) (To Be Cospleted By		(Date)
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Sur To:	oship San Diego	-4.5 Oct	1981	1509-10	#55
	Bay City Marine	BCM 116	5-81	· · · · · · · · · · · · · · · · · · ·	
	1411 Harding Ave. National City. Ca. 92050	Code We	eldina		
• 5 .	•••				
al-CR	1-6 Hull No. 56CM6761				
	SPECIFICATION		PAGE	LINE P	ARAGRAPH
	NAVSEA Standard Item		2 of 2	3	.6 & 3.6.1
	DRAWING NO.		REV.	*;	
	PROCEDURE NO.		PARAGRAPH	PAGE	
	OTHER (Specify)				
				<del> </del>	
	THE FOLLOWING DEFICIENCY (188) REQUIRE COR	-	TION AS TO CAUSE		
ΔJ	CRIPTION OF DEFICIENCY(IES):	LAI			
2.	3.6.1 Tag each cable indication of boat on ads and equipment were not tapp  Contractors records do not ad  This item was discussed with	4 Oct 1981 it ed or tagged.  dress this ar	was discovere	·	
			,		
				e on Back if No	re Space Required
<u> </u>		00E 1509-1D	5 Oct 198	1	
ts.	It is requested that a reply in provided to Supship Code 1509-	dicating the 1D by 12 Oct	corrective act 1981.	ion taken o	to be taker
14.	CONTRACTOR'S REPLY (Authorized Representa	tive) ·			
	-				
			-		
		<del></del>	(Signature)		(Date)
5.	VERIFICATION & EVALUATION STATEMENT OF CO	NTRACTOR'S ACTION		y Govt. Rep.)	
		SIGNATURE	· <b>:</b>	DATE:	

Page

QUALITY DEFICIENCY RECORD - HARDWARE (*Optional Items) MAYSHIPS 4355/14 (9-72) (FRONT) Supship San Diego 5 Oct 1981 1509-1D #51 TO: Bay City Marine BCM 116-81 1411 Harding Ave. National City, Ca. 92050 Code Welding CM-6 Hull No. 56CM6761 SPECIFICATION FAOL PARAGRAPH Standard Item 009-04 4 of 5 3.4.2 DRAWING NO. PROCEDURE NO. PARAGRAPH PAGE OTHER (Specify) 10. THE FOLLOWING DEFICIENCY(IES) REQUIRE CORRECTIVE ACTION AS TO: X CORRECTION OF DEFECT X CORRECTION AS TO CAUSE DESCRIPTION OF DEFICIENCY (1ES): Para. 3.4.2 states: Notify the supervisor at least 4 hours but not more than one day prior to commencing the specific test and inspection in the paragraph following a check point. 2. Contractor scheduled check points for both Saturday 3 Oct 1981 and Sunday 4 Oct 1981 at 1400. A. On Saturday 3 Oct 1981, Supship arrived for check point at 1400 and found Quality Sandblast yard to be secured. Supship departed at approximately 1415 and at that time contractor was still not present. B. On 4 Oct 1981 Supship arrived at 1345. The only personnel present were sandblasters from Quality Sandblasting. At approximately 1410 the Q.A. Rep. from contractor called and asked how it looked. He also stated that he would not be able to appear for the scheduled check point time. Contractors records do .not address this area. (Continue on Back if Hore Space Required) 11. AUTHORIZED GOVT. REP. (Signature) CODE b7C 5 Oct 1981 1509-1D "It is requested that a reply indicating the corrective action taken or to be taken be provided to Supship Code 1509-1D by 12 Oct 1981. (Signature) (Date) 15. VERIFICATION & EVALUATION STATEMENT OF CONTRACTOR'S ACTION (To Be Completed By Govt. Rep.)

SIGNATURE: DATE:

LÉT1	TER OF	TRANSMITT	AL	No. <u>1.01</u>	11A	·
FROM:  BAY CITY MARINE, IN  1411 Harding Avenue  National City, CA 92050	JC.	Contract: 116 Vessel: 1	<b>C</b> 4-8		16_26_1 74CH6781	
TO: Supervisor of Shipbuilding Conversion and Repair, USN U.S. Naval Station, Box 119 San Diego, California 92136		Spec. S/D	688-81	Mod.		
Attn: Code #					;	ь6 ь7с
☐ Required Report(s) ☐ Schedule of Events		Enclosure(s	ULL UNSPECTION	J PIR PAR	A 3 16 (	OF ITE
☐ Excess Material ☐ Supships S/ > 4500/2			83-41-004 PT 1		रिदे करणाल्या च	
☐ Drawing(s) ☐ Test Memo						
☐ J.O. Exception(s) Completed						
Comments:						to the second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second se
REQUEST FORMAL HELL	INSPECT	1 <b>0</b> 11 0900, 10-	<b>22-81</b>			*
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BAY CITY MARINE, INC.  Signature: Date:	the state of the	Supships Signature:		D:	ate:	1 2

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	CDC IDR# 1323	
•	DATE SUBMITTED 10-21-81	
	· CONTRACT NO	
	SUPSHIP PLANNER	
	C.D.C, W.O.# 2198	
INSPECTION/ DEFICIENCY RÉPORT		
CONTRACTOR: Bay City Marine		
ATTENTION:SUBJ: USS	SPEC NO.	_b6 b7С
ITEM NO. 583-41-002 PT TV MOD		
OF IX CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIF		
Paragraph 3.22 of the basic specifications calls and debris from centerline voids. Paragraph 3.24 loose rust from port and starboard voids. Rust is and cannot be considered as loose rust. Contract to mechanically clean or preserve voids.	l calls to remove is very thick in voids,	
CONTRACTOR'S RECOMMENDED ACTION:		
Issue Contractor a change order to mechanically centerline, port and starboard voids.	clean and preserve	

1411 HARDING AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

'A: CODE # 1509-D UBJECT: USS LCM-6

SPEC. PKG. NO. SD

ART. NO.

REPORT NO. 116-2 DATE SUBMITTED 10-8-81 CONTRACT NO. BCM 116-81

PLANNER/SURVEYOR

INSPECTION DATE 10-7-81

: CW-1348-2

MOD.

INSPECTION / DEFICIENCY REPORT

-688-81

583-41-002

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

VISUAL INSPECTION REVEALS THE FOLLOWING:

- 1) PORT RUDDER POST BADLY BENT
- 2) PORT RUDDER BLADES BADLY DETERIORATED
- 3) STARBOARD RUDDER BADLY DETERIORATED

#### CONTRACTOR'S RECOMMENDED ACTION

ISSUE CONTRACTOR CHANGE ORDER TO RENEW PORT RUDDER STOCK TO BE STAINLESS STEEL.	AND STARBOARD	RUDDERS (BLADES AND STOCK).
	o i de la la mail a e é e	CONTRACTS  B 9 50 M '81
PLY REQUESTED BY: URGENT	SIGNATURE OF ORIGINATOR	F
RVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATE OVERED IN BASIC SPEC, PARA 3.9.6	PART 8	b6 10-19-61 b7C DATE



TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D SUBJECT: USS LCM-6 BILGE PUMPS

SPEC, PKG, NO, SD

ART. NO.

REPORT NO. 116-15 DATE SUBMITTED 10-15-81 CONTRACT NO. BCM 116-81

PLANNER/SURVEYOR

INSPECTION DATE

RE:

MOD.

b6

b7C

**INSPECTION / DEFICIENCY REPORT** 

688-81 ·

583-41-002

CW1348-13

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

Contractor has been unable to locate bilge pumps identified in reference 2m. Delivery from factory is (8) eight to (10) ten weeks. Sources for procurement of bilge pumps were:

1. Kettenburg Marine- San Diego, California

2. Generator Equipment-Los Angeles, California

3. Associated Diesel Service- Wilmington, California

### CONTRACTOR'S RECOMMENDED ACTION

Issue contractor change order to repair the new bilge pumps upon arrival.	existing bilge pumps and to	urn over to ship
,	s.	<b>l</b> 63 15
	*	NTRACT 9 53 1
	SIGNATURE OF ORIGINATOR	
EPLY REQUESTED BY:	MENDATIONS	
CONTENCTOL AUTHORITED TO REPAIR ICE IVEW AT NO PODITIONAL COST		DATE



BOW RAMP WINCH

NG AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D SUBJECT: USS

SPEC. PKG. NO. SD

ART. NO.

RE: CW1348-14

REPORT NO. 116-21 DATE SUBMITTED

CONTRACT NO. BCM 116-81 PLANNER/SURVEYOR INSPECTION DATE

b6 b7C

LCM-6

Issue change order to:

688-81

MOD.

INSPECTION / DEFICIENCY REPORT

10-19-81

10-15-81

583-41-002

VIII

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

to a st by

Upon inspection it was noted that:

- Pilothouse controls to winch are bent and twisted.
- 2. Lower winch cantilever is loose in bore
- 3. The arms from cantilever are missing.

### CONTRACTOR'S RECOMMENDED ACTION

2.	Renew levers from pilothouse to a Ream lower cantilever and clevis Manufacture and install new winc	and manufacture oversized pin	S. 👼
			<b></b>
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			6
		SIGNATURE OF	
		ORIGINATOR	
EDLY DECLIERTED	URGENT		
EPLY REQUESTED  COMPLETE ARTI	CLE WITHIN AVAILABILITY		
PERVISOR OF SHE	IPBUILDING REPRESENTATIVES FINDINGS AND/OR RE	COMMENDATIONS	

REQUIRED MOT DUE TO NO WINCH

Ne AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D SUBJECT: USS LCM-6

REF.

SPEC, PKG, NO, SD

688-81

INSPECTION / DEFICIENCY REPORT

REPORT NO. 116-22. DATE SUBMITTED 1-=19=81 CONTRACT NO. BCM 116 - 81PLANNER/SURVEYOR INSPECTION DATE 10 - 15 - 81

RE: CW1348-15

ART, NO.

583-41-002

b6 b7C

MOD.

THROTTLE CONTROLS CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

1. The throttle control rods are bent and frozen.

Throttle control brackets are wleded instead of being bolted.

## CONTRACTOR'S RECOMMENDED ACTION

Issue change order to:

Renew the throttle control rods.

Fabricate and install new brackets, bolted with grade 5 bolts and nuts,

	•••			<b>⊣</b>	A1.475.46 784
	•		۳ د	20	
	SIGNATURE OF ORIGINATOR				
1		· · · · · · · · · · ·			

URGENT REPLY REQUESTED BY: .

TO COMPLETE ARTICLE WITHIN AVAILABILITY

PERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

CONTRACTOR COYERED IN PARAS. 3,12 & 3,13 OF BASIC.

RDING AVENUE . NATIONAL CITY, CA 92050 . (714) 474-8121

O: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D SUBJECT: USS

REF.

LCM-6

SPEC. PKG. NO. SD

688-81

ART. NO.

RE: CW1348-16

REPORT NO. 116-23

CONTRACT NO. BCM

PLANNER/SURVEYOR

DATE SUBMITTED 10-19-81

INSPECTION DATE 10-15-81

MOD.

b6

b7C

INSPECTION / DEFICIENCY REPORT

116-81

583-41-002

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

Upon inspection it was noted that the starter accumulator bracket is broken.

#### CONTRACTOR'S RECOMMENDED ACTION

Teena	change	order	†a	manufacture	and	install	new	starter	accumulator bracket	
issue	Change	order	LΘ	manuracture	allu	, mocari	HEW	3 car cer	accamarator bracket	•

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	•				Oct 19
	•		SIGNATURE OF ORIGINATOR		-
REPLY REQUESTED BY:TO COMPLETE ARTICLE WITHIN AVAIL.	URGEN	<u>IT</u>			

PERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

NO ADDITIONAL WORK AUTHORIZED

,	10-21-81 DATE	



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TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

"IA: CODE # SUBJECT: USS

REF.

1509-1D LCM-6 SPEC. PKG. NO. SD

ART. NO.

REPORT NO. 116-25 DATE SUBMITTED

PLANNER/SURVEYOR

INSPECTION DATE

CONTRACT NO. BCM 116 01

CW1348-18

MOD.

b6

b7C

583-41-002 PT VIII

**INSPECTION / DEFICIENCY REPORT** 

116-81

10-15-81

688-81

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

"AS FOUND" report on line shaft Required "as found" report of line shaft

CONTRACTOR'S RECOMMENDED ACTION

REQUIRED REPORT IAW 3.9.3 & 3.9.5

SIGNATURE O

REPLY REQUESTED BY: . COMPLETE ARTICLE WITHIN AVAILABILITY

PERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

REPORT RECEIVED & NOTED.



REPORT RECEIVED & NOTED

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D SUBJECT: USS LCM-6

REF.

SPEC. PKG. NO. SD

688-81

**INSPECTION / DEFICIENCY REPORT** 

DATE SUBMITTED 10-19-81
CONTRACT NO. BCM
PLANNER/SURVEYOR
INSPECTION DATE

583-41-002 PT VIII

10-21-81 DATE

RE: CW1348-19

ART. NO.

b6 b7C

MOD.

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

"AS FOUND" report on main propulsion engines 671 RC 2851A #4 and 671 RC 2851 #3.

CONTRACTOR'S RECOMMENDED ACTION

REQUIRED REPORT			
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	e transmission of the s	•	AGT.
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EPLY REQUESTED BY:	· · · · · · · · · · · · · · · · · · ·		
JPERVISOR OF SHIPBUILDING REPRESENTATIVES FI	INDINGS AND/OR RECOMMENDATION	IS.	•



SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # SUBJECT: USS

REF.

SPEC. PKG. NO. SD

ART. NO.

REPORT NO. 116-28 DATE SUBMITTED 10-19-81 CONTRACT NO. BCM 116-81

PLANNER/SURVEYOR INSPECTION DATE

RE: CW583-41-002 PT III

b6 b7C

MOD.

INSPECTION / DEFICIENCY REPORT

10-19X81 -21

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

Contractor noted:

NO MODITIONAL

WOLK

- Line shaft is worn is way of cutless and packing LCM-6-P.
- Line shaft is worn is way of cutless and pack in area LCM-6-S.

## CONTRACTOR'S RECOMMENDED ACTION

	Issue	C01	ntra	cto	r a	change	e or	der	to (	undei	rcut.	area	a in	way	0†	pack	เาng	ar	ea a	nice c	uties	SS.
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PERVISOR	OF SHIP	DOILD	MING H	CLHE	DEN I A	KIIVES FI	MDING	is and	VOR R	RECOM	MENDA	TIONS	;									

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NG AVENUE • NATIONAL CITY, CA 92050 • (714) 474-8121

TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D SUBJECT: USS

REF.

LCM-6

SPEC. PKG. NO. SD

688-81

RE: CW1348-20

ART. NO.

REPORT NO. 116-27 DATE SUBMITTED 10-19-81 CONTRACT NO. BCM 116-81 PLANNER/SURVEYOR

INSPECTION DATE 10-15-81

MOD.

b6

b7C

583-41-002 PT VIII

INSPECTION / DEFICIENCY REPORT

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

"AS FOUND" blower reading Serial #6-71 RC 2851 A XXX#4

CONTRACTOR'S RECOMMENDED ACTION

REQUIRED RPEORT IAW PARA 3.4.6

SIGNATURE O

REPLY REQUESTED BY: _ O COMPLETE ARTICLE WITHIN AVAILABILITY

PERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

REPORT RECEIVED & NOTED.



TO: SUPERVISOR OF SHIPBUILDING CONVERSION AND REPAIR, SAN DIEGO, CA 92136

:VIA: CODE # 1509-1D SUBJECT: USS LCM-6

SPEC, PKG, NO. SD

688-81

ART. NO.

ь6 ь7С

RE: CW1348-22

·INSPECTION DATE

REPORT NO. 116-29

CONTRACT NO. BCM

PLANNER/SURVEYOR

DATE SUBMITTED 10-19-81

MOD.

583-41-002 PT VIII

**INSPECTION / DEFICIENCY REPORT** 

116-81

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

AS RELEASED BLOWER READINGS SERIAL #6071RC 2851A #4

REPORT KECEIVED & NOTED

CONTRACTOR'S RECOMMENDED ACTION	Oct	*
REQUIRED REPORT IAW PARA 3.4.6	<u></u>	001
	3 01 PH '81	CONTRACTS
SIGNATURE OF ORIGINATOR		CONTRACTS  July Spirit Gl
PLY REQUESTED BY:  COMPLETE ARTICLE WITHIN AVAILABILITY  PERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS		



UPERVISOR OF SHIPBUILDING

CONVERSION AND REPAIR, SAN DIEGO, CA 92136

VIA: CODE # 1509-1D SUBJECT: USS LCM-6

SPEC. PKG. NO. SD

ART. NO.

REPORT NO. 116-30 DATE SUBMITTED 10-19-81 CONTRACT NO. BCM 116-81

PLANNER/SURVEYOR

INSPECTION DATE 10-15-81

CW 1348-23

MOD.

b7C

688-81

583-41-002 PT IV

INSPECTION / DEFICIENCY REPOR

CONDITIONS FOUND (NOT COVERED IN ORIGINAL SPECIFICATIONS)

# VOIDS

After removal of loose rust from centerline voids and port and starboard voids, it was noted that voids have heavy rust deposits and deteriorated plate, frames, and stiffeners.

## CONTRACTOR'S RECOMMENDED ACTION

Issue contractor change order to sandblast port and starborard and centerline voids Crop out deteriorated plate, frames and stiffeners and replace with new.

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	SIGNATURE CORIGINATOR	F			

REPLY REQUESTED BY: ___

TO COMPLETE ARTICLE WITHIN AVAILABILITY

PERVISOR OF SHIPBUILDING REPRESENTATIVES FINDINGS AND/OR RECOMMENDATIONS

NO ADDITIONAL WORK AUTHORIZED

		,	
10-	21-81	<b>;</b> .	
*	DATE ,	₹`	11.0